

Date: Wednesday, 10/10/2007 11:01:59 AM  
 User: Kim Johnston

## Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH  
 Job Number : 35070  
 Estimate Number : 10800  
 P.O. Number : N/A Part Number : D350600141  
 This Issue : 10/10/2007 S.O. No. : N/A Drawing Number : IIN REV.C PG11,18-21  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C  
 Previous Run : 33901 Material : N/A  
 Due Date : 11/15/2007 Qty: 1 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature]  
 Comment : Est Rev:B 05.04.14 Incorporated procedures from D3187-1/-2 K  
 J/JLM  
 Est Rev:E 06-11-20 As per DSI9335 JLM  
 est rev F 07.02.07 iin rev.c ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

K8 07.10.15  
+DSI 9394

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

J 07/12/12

2.0 35070A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

1 x D350-600-349 B

34742

B 07/12/12

3.0 35070B SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: 35070B

ml 07/12/06

4.0 35070C SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-1 B 35070C

ml 07/12/06

5.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D3187-1 Floor B3183-5  
 1 D3186-1 Door (ref) B35070C  
 1 D3188-1 Body(ref) B35070B

ml 07/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 ALS4-1032-130 Insert M105730

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3188-1 body floor to Ø0.297".

2-Install inserts in D3188-1 as per Dwg D3188.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number Description Batch

5.62SF D2986 Neoprene Foam B 30632

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: M 102565

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Washer - Countersunk *M106150*

13.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
✓ DECAL  
batch: *B31127*

14.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
✓ Pick:  
Batch: *M13459*

15.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
✓ BRACKET  
batch: *B31125*

16.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
✓ Pick:  
Batch: *B33486*

17.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
✓ BALL STUD  
batch: *B30210*

18.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
✓ Pick:  
Batch: *M104156*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D30153

Lock Nut



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓

Pick:

Batch: 334197

20.0

MS20426AD46

Rivet



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓

Rivet

Batch: M103395

21.0

D35381

HINGE BRACKET



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓

HINGE BRACKET

batch: D35454

22.0

D2179

Doubler



*CP*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓

Pick:

Batch: B36630

23.0

AN526C832R14

Screw



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓

Screw

batch: M9216

24.0

AN960JD8

Washer



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓

Washer

batch: M105057

25.0

MS21042L08

Nut



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓

Nut

batch: M105430

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for body & floor\*\*\*\*

N/\* ml 07/12/10

27.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ CARBON STEEL GAS SPRING  
batch: B30673

28.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Screw  
batch: M104427

29.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ Washer  
batch: M105067

30.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Washer  
batch: M105164

31.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Nut  
batch: M105430

32.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

✓ 3/4 Seal  
Cut 127.00" long batch: B30681

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Door Latch  
batch: B35802

34.0

D2585

Latch Clamp



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Latch Clamp  
batch: B33487

35.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Latch Plate  
batch: B32355

36.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Screw  
batch: M105108

37.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Washer  
batch: M105792

38.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ Nut  
batch: M105558

39.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Hinge Bracket  
batch: B33942

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Backing Plate  
batch: B30679

41.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Screw  
batch: M104603

42.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Washer  
batch: M105057

43.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

✓ Nut  
batch: M105430

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Hinge Bracket  
batch: B33453

45.0

D35481

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ BRACKET  
batch: B30245

46.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ BALL STUD  
batch: B30210

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M104156

48.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B34197

49.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

mlo 07/12/10 <sup>XL</sup>

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/10

51.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M106030

BR 07-12-10 <sup>1X</sup>

52.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M-A 07/12/11

53.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

35094

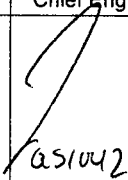
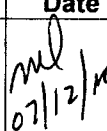


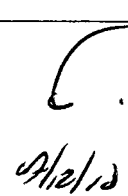
1 D3187-1(Ref)

Spacepod Floor

31935

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/12/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/10	50	5 rivets are not good	 AS1042	Drill out 5 rivets replace them by new one B# M3459 MS 20426 AD 4-5	 ml 07/12/10	 AS1042 7/12/10	 AS1042 7/12/10	 7/12/10

NOTE: Date & initial all entries



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Job Number: 35070

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*AS 07/12/12* (XV)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*B*

*AS 07/12/12* (XV)

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*AS 07/12/13* (1)

Job Completion



*mic 2007 1/2/12*  
*✓*

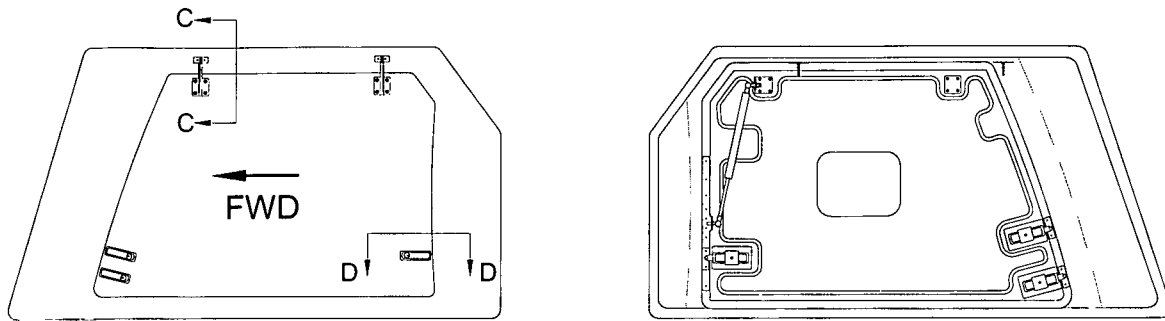
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

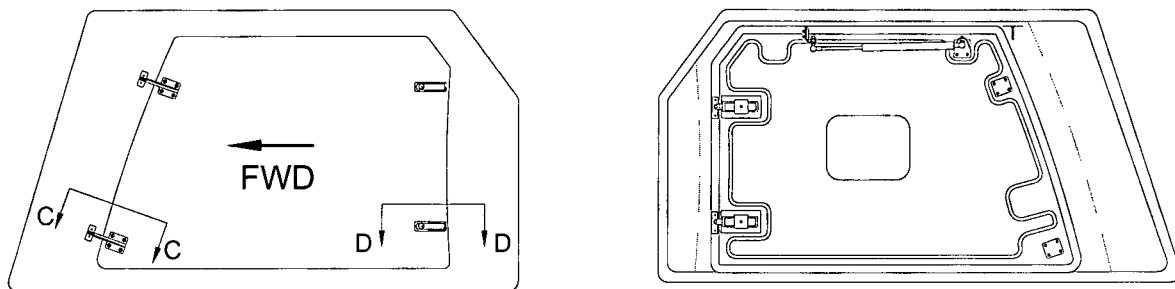
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

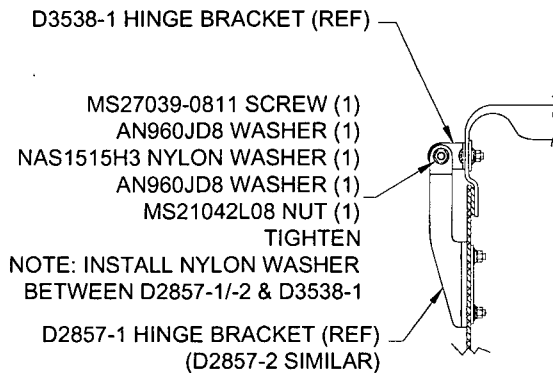
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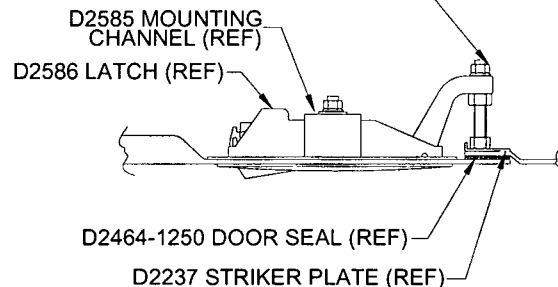
**FIGURE 6(a).** -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b).** -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE  
COMPRESSION OF DOOR SEAL  
AND LOCK IN POSITION WITH NUT



**SECTION 'C-C' HINGE**  
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

**SECTION 'D-D' LATCH**

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
  - If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
  - Re-install the belly panel per the Aircraft Maintenance Manual.

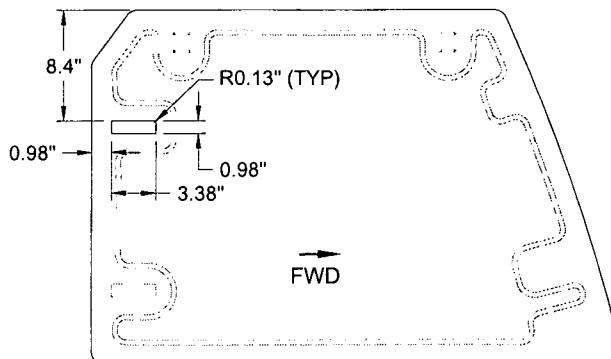
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35070

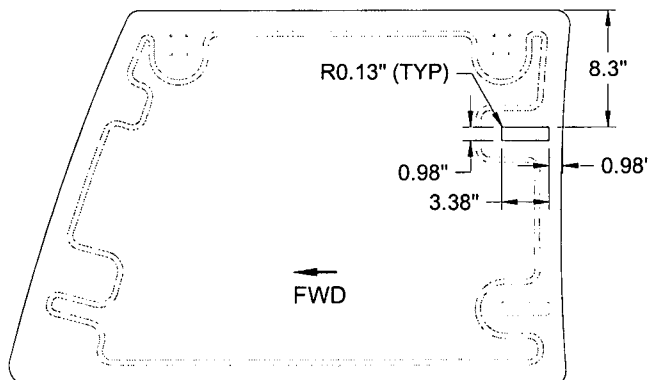
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Revision: C  
Date: 07.02.20

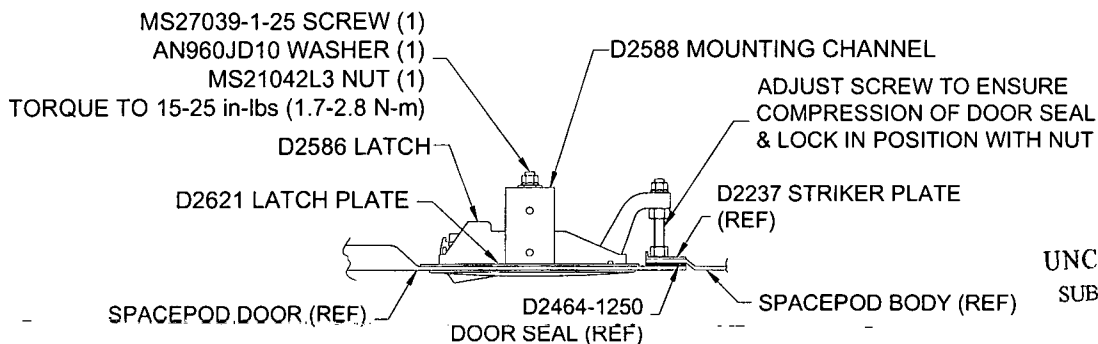
- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).



**FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -041I-043I-141I-143 KITS)



**FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -042I-142 KITS)



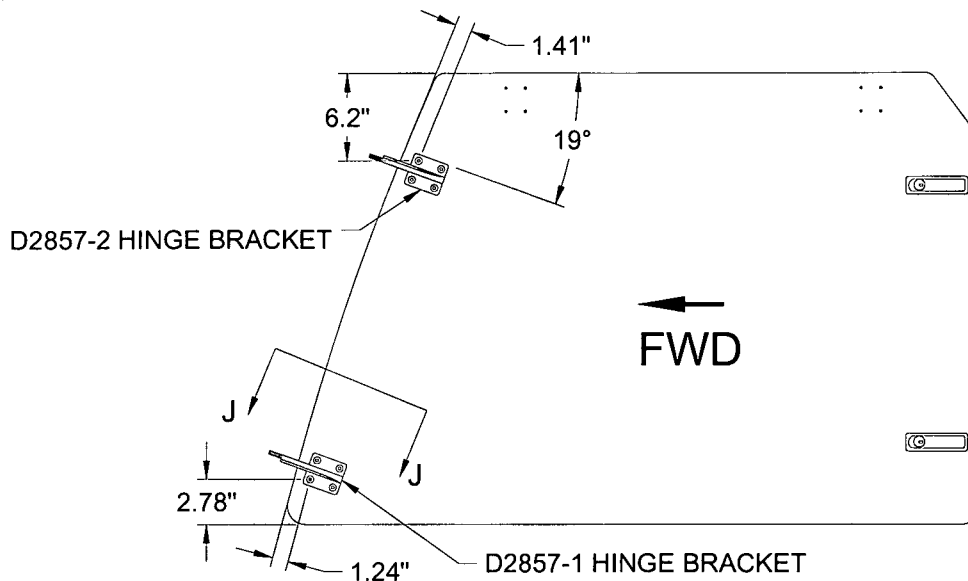
**FIGURE 14(c). LATCH INSTALLATION**  
(SHOWN WITH DOOR INSTALLED ON POD)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35070

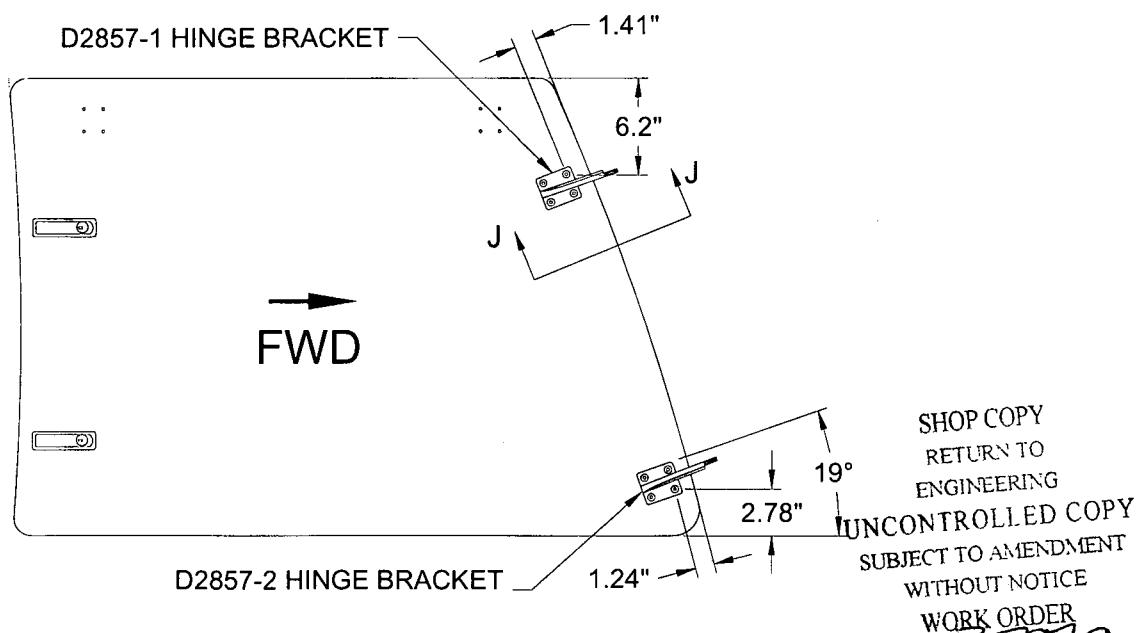
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Revision: C  
Date: 07.02.20

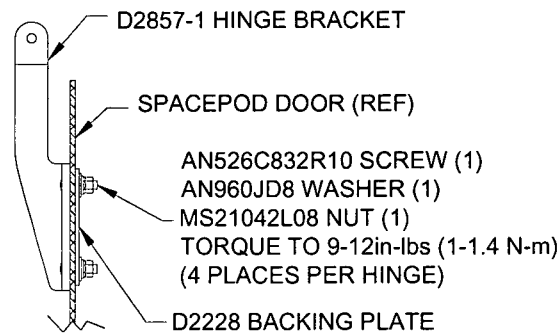
- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.



**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**

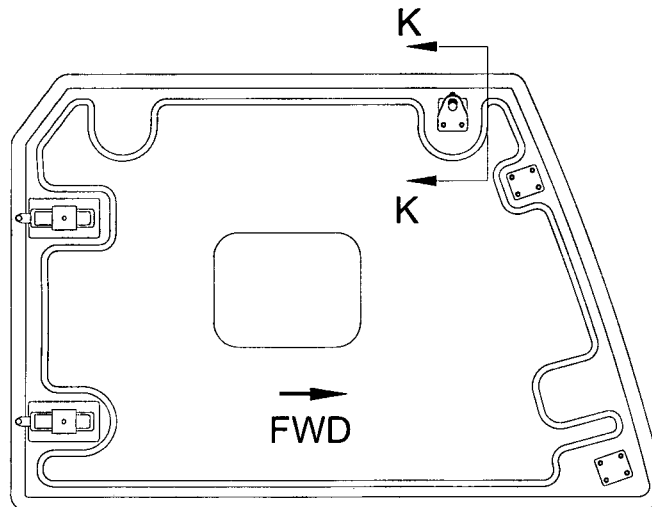


**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

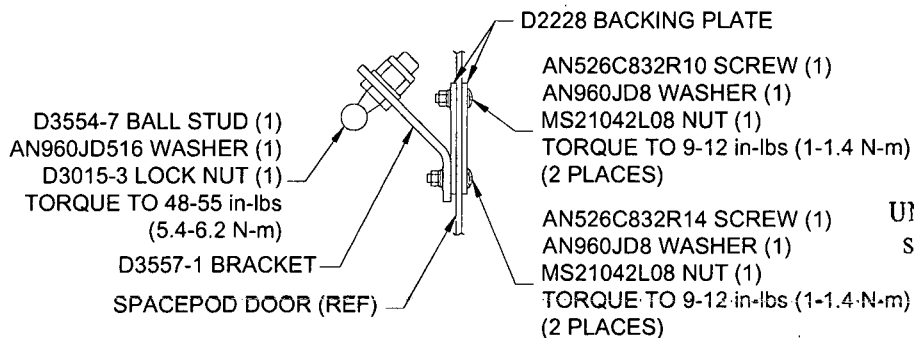


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



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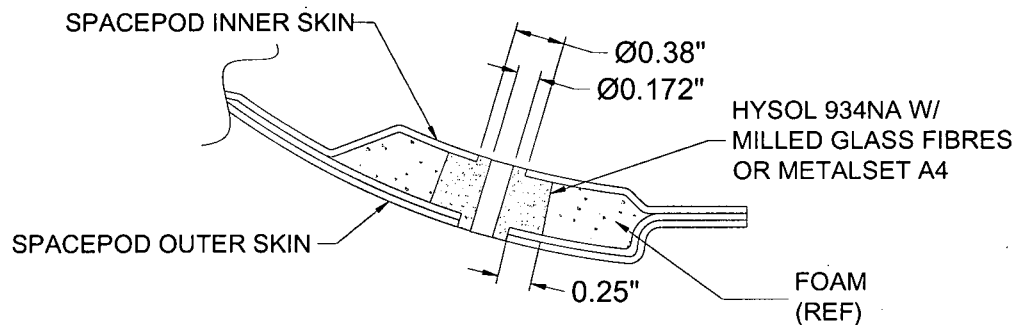
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WORK ORDER  
NO. 35070

**SECTION 'K-K'**

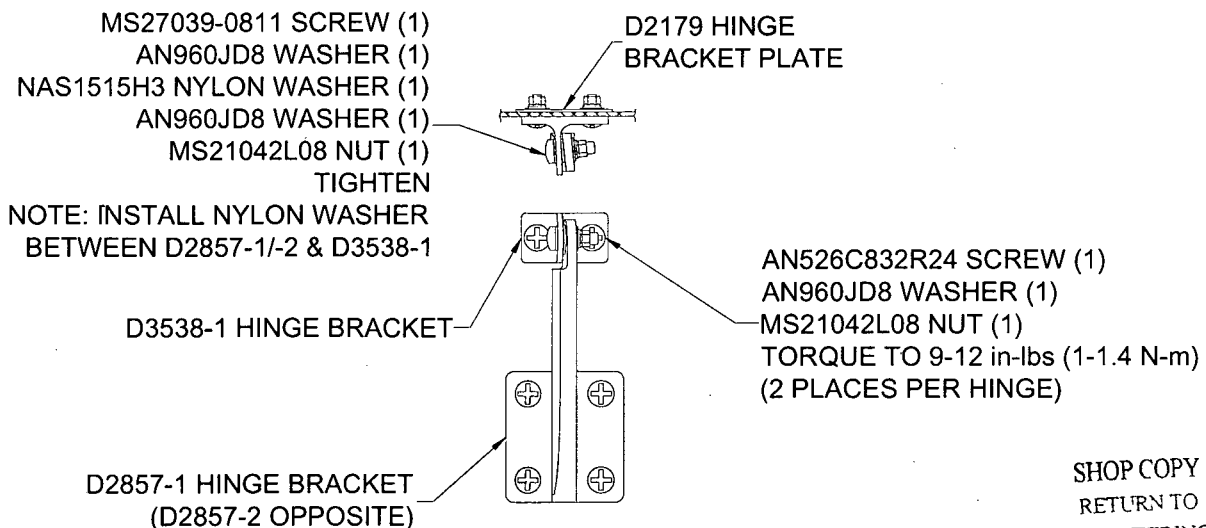
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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).



**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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Revision: **C**  
Date: 07.02.20

Date: Wednesday, 10/10/2007 11:02:09 AM  
 User: Kim Johnston

## Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR LH
Job Number : 35070C	
Estimate Number : 11095	
P.O. Number :	Part Number : D31861
This Issue : 10/10/2007 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 33901C	Material : N/A
Written By :	Due Date : 11/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>10/07/10</u>	
Comment : Est Rev:A New Issue 05-11-29 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	35070C01	SPACEPOD DOOR LH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-1 detail)

ml 07/12/06

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 2/12/06 (cc)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

x1

ml 07/12/06

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

D 07/12/13

Job Completion



ml 07/12/12

W



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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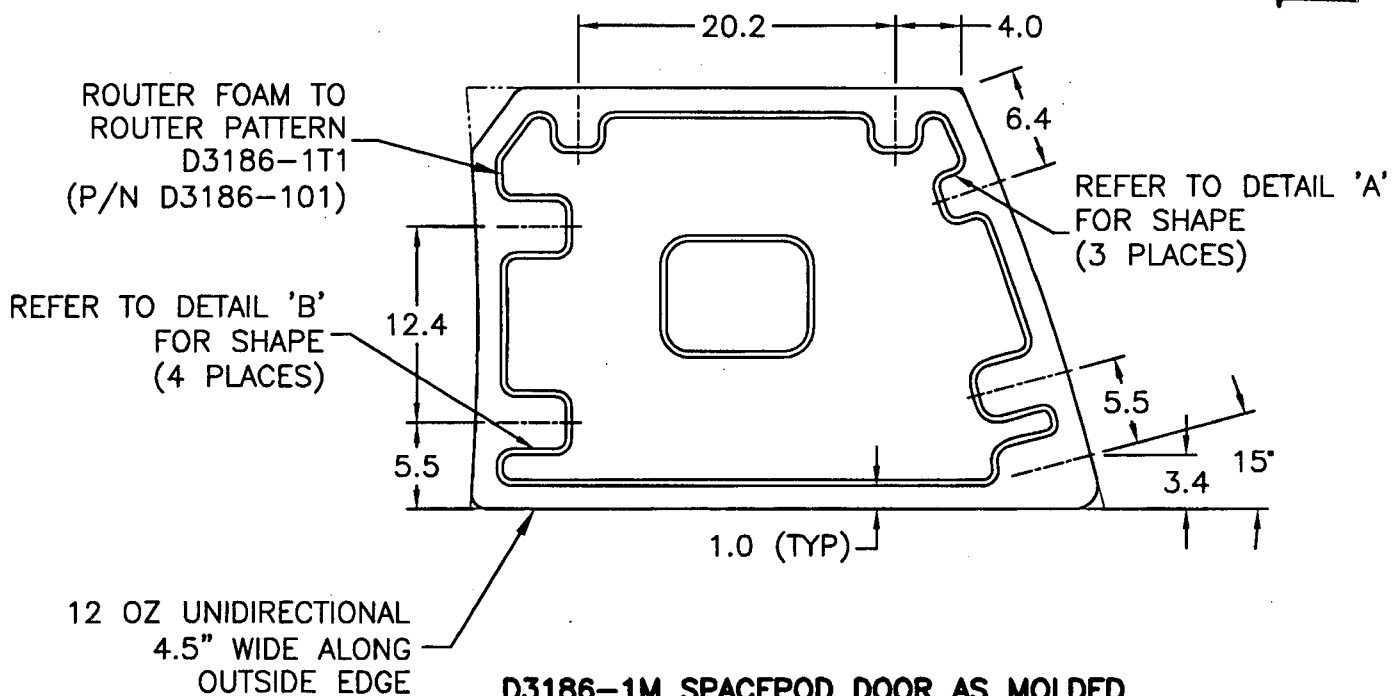
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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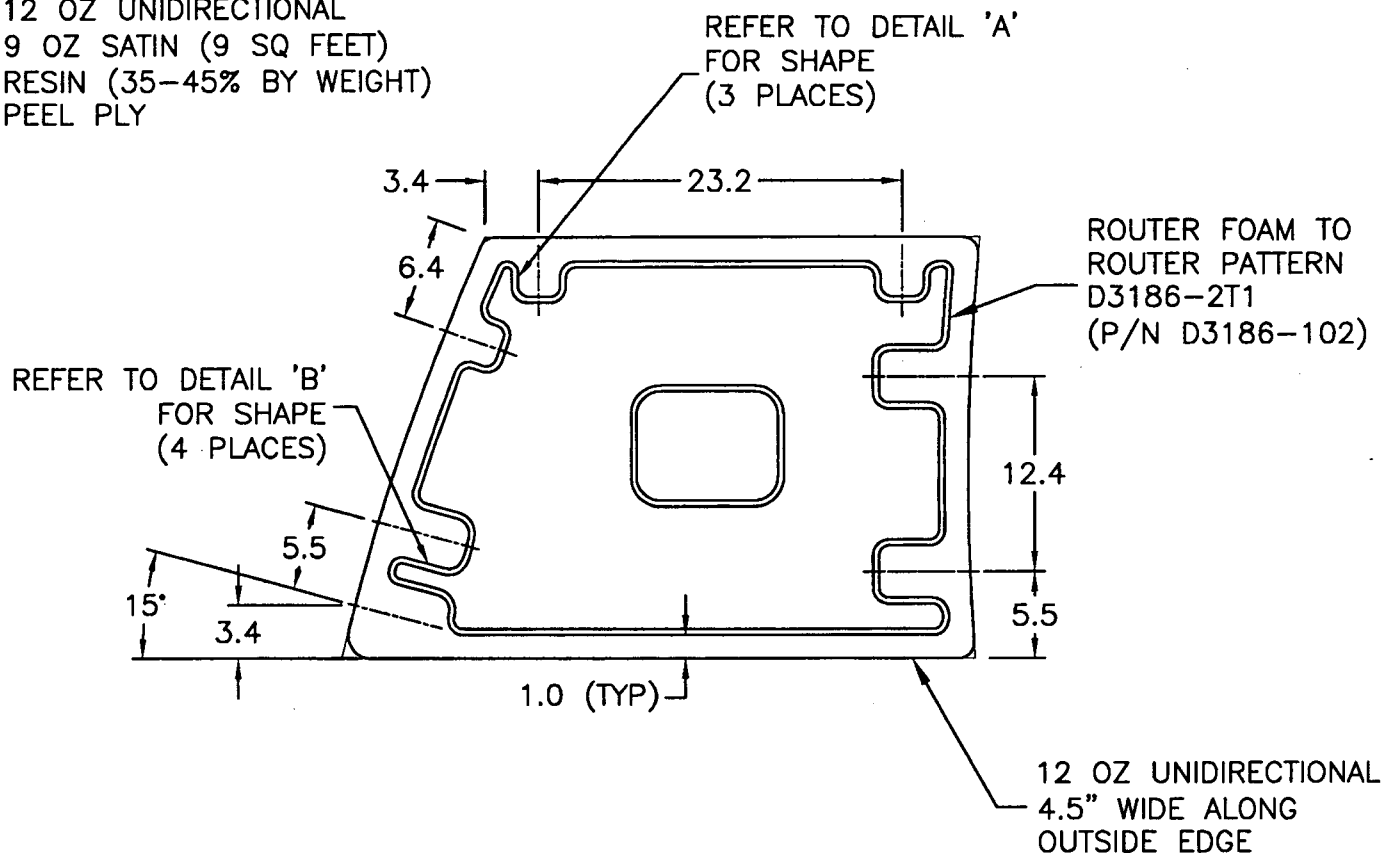
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

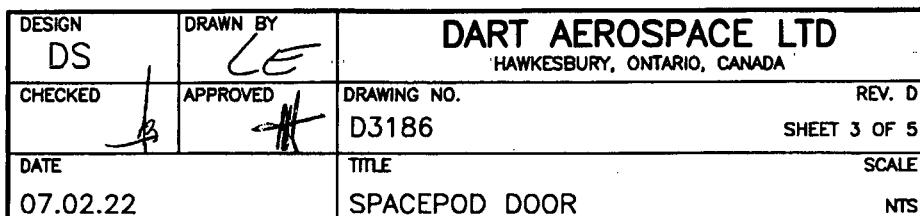
**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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07.02.27

REFER TO DE FOR CUTOUT (3 PLACES)

20.25

4.70

1.80

5.50

5.50

3.46

15°

0.98 (TYP)

**D3186-1 SPACEPOD DOOR, LH**  
**(MAKE FROM D3186-1M)**

REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

REFER TO DETAIL 'E'  
FOR HOLE DETAILS  
(2 SETS)

0.98 (TYP)

12.45

5.50

3.59

1.80

5.85

1.41

2.78

1.24

19°

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**D3186-3 SPACEPOD DOOR, LH**  
**(MAKE FROM D3186-1M)**

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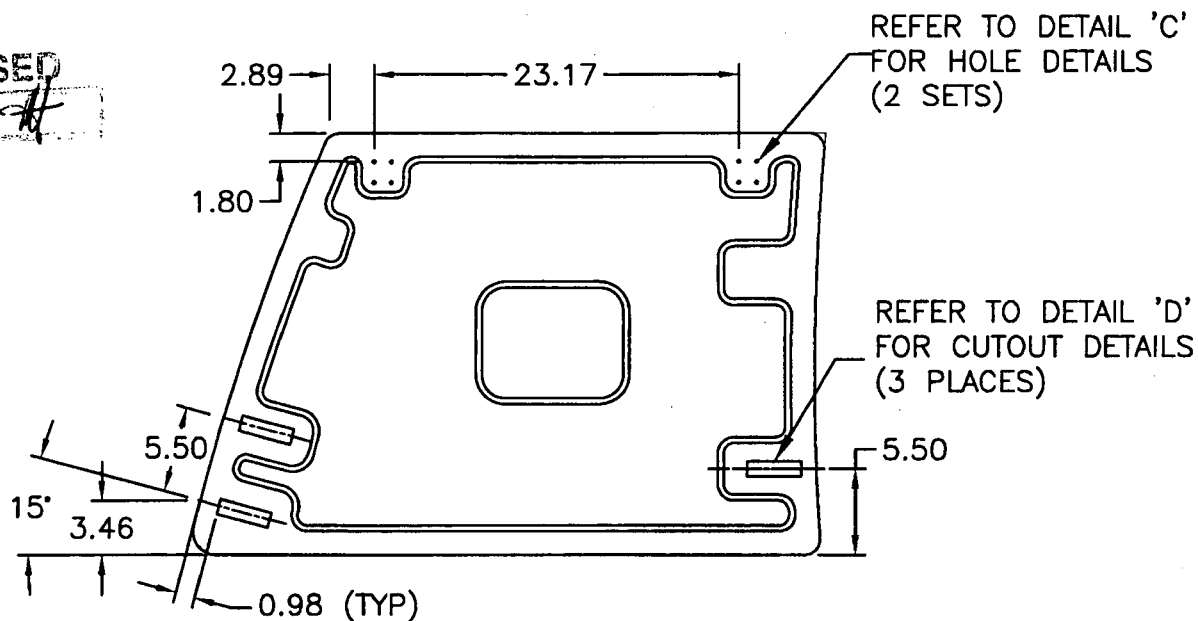
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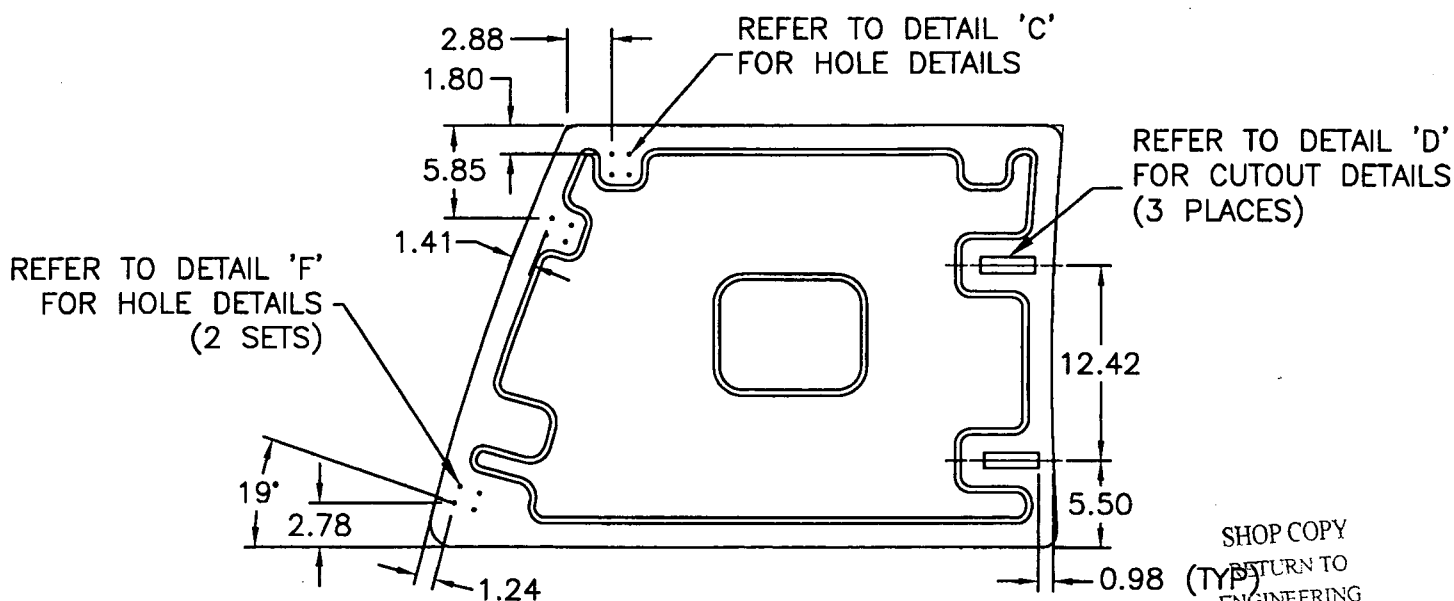


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

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07-02-27



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

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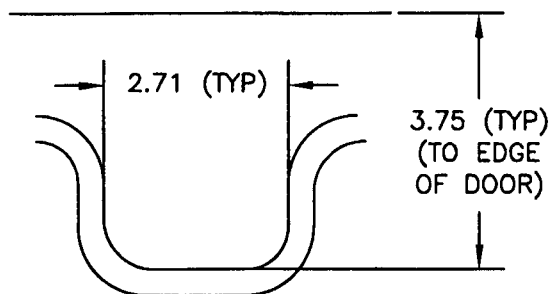
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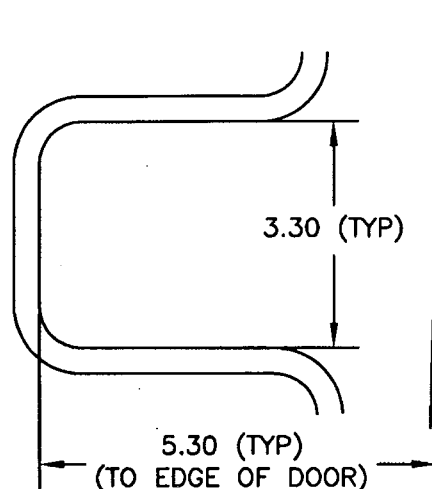
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



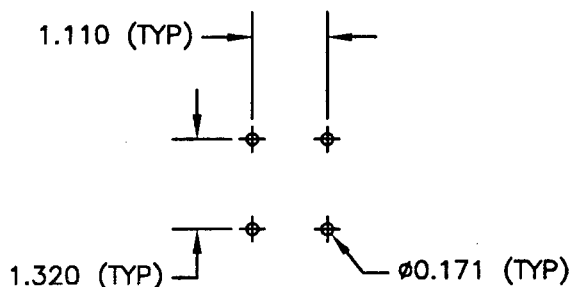
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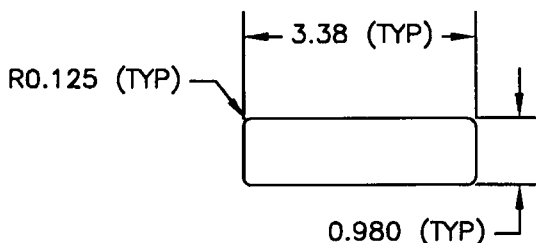
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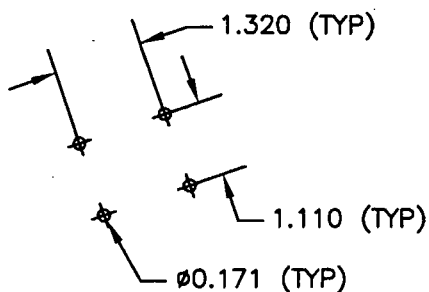


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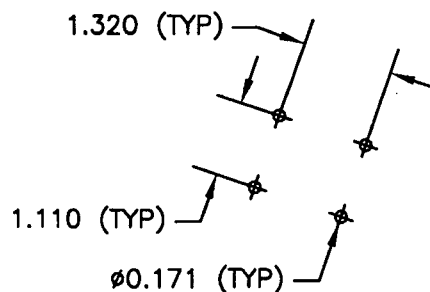


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

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Date: Wednesday, 10/10/2007 11:02:09 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD BODY LH  
Job Number : 35070B  
Estimate Number : 12595  
P.O. Number : Part Number : D31881M  
This Issue : 10/10/2007 S.O. No. : Drawing Number : D3188 REV.E  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : SMALL /MED FAB Drawing Revision : E  
Previous Run : 33901B Material :  
Written By : Due Date : 11/15/2007 Qty: 1 Um: Each  
Checked & Approved By : 071010  
Comment : Est Rev:A New issue ecn882 06-11-30 EC  
est rev B revc dwg 07.01.11 ec  
est rev C revD dwg 07.03.07 ec  
est rev D rev E dwg 07.04.16 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Ship To Delastek

8 D2213 Spacer Batch: 30107 C26711112 ⑧

2.0 PG PURCHASING



Comment: PURCHASING  
Issue P/O: 4784 C26711011  
Description: D3188-1M BODY  
Ship: D2213 Spacers ①  
Supplier: Delastek  
Conformity Certificate and Process sheet required  
Ship 2 Items from Previous steps

3.0 D31881P Spacepod Body



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Body

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 10/10/2007 11:02:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 35070B

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/12/06*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①

*07/12/13*

Job Completion



*ml 2007/12/12*  
*U*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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07.04.02

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JB	CB	HAWKESBURY, ONTARIO, CANADA
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DATE 07.04.02	DRAWING NO. D3188	SHEET 1 OF 11
	TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11

**GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

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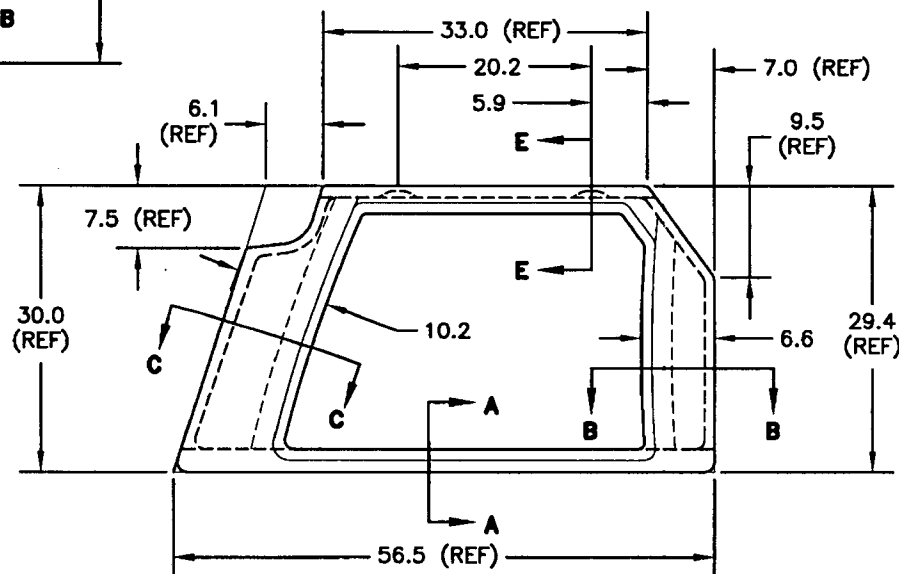
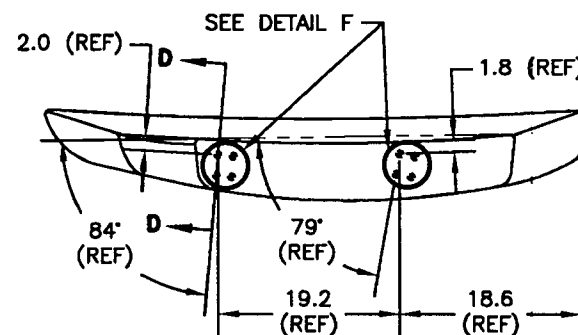
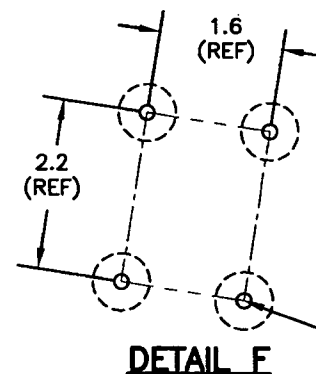
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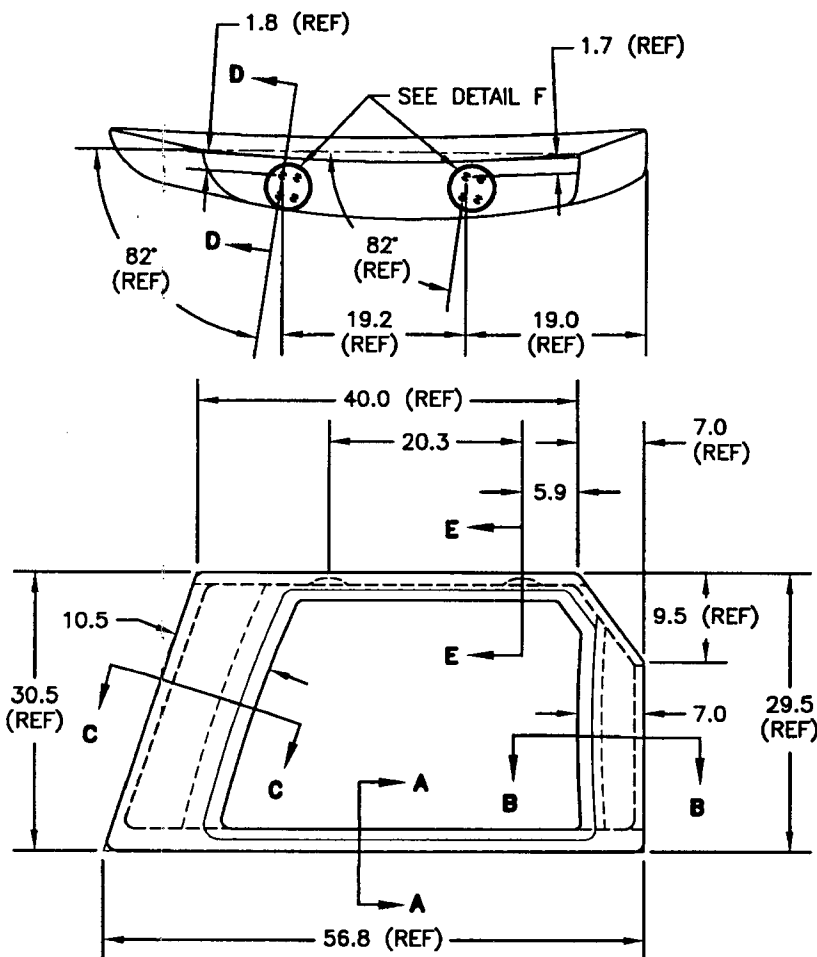
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07-04-01

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-3M SPACEPOD BODY**



**D3188-1M SPACEPOD BODY**

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JB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CE	[Signature]	D3188
DATE	TITLE	REV. E
07.04.02	SPACEPOD BODY	SHEET 2 OF 11
		SCALE
		NTS

**D3186-1M/-3M NOTES:**

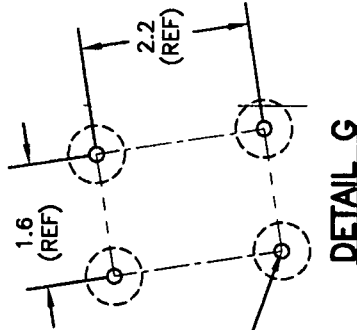
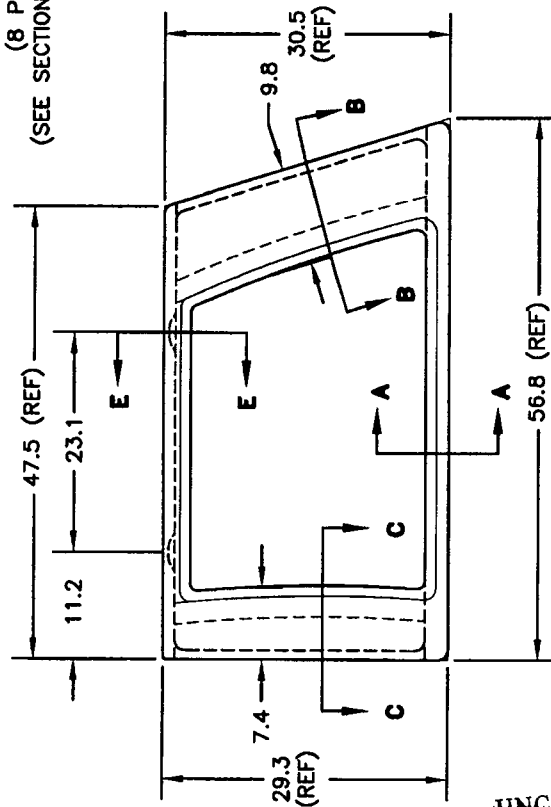
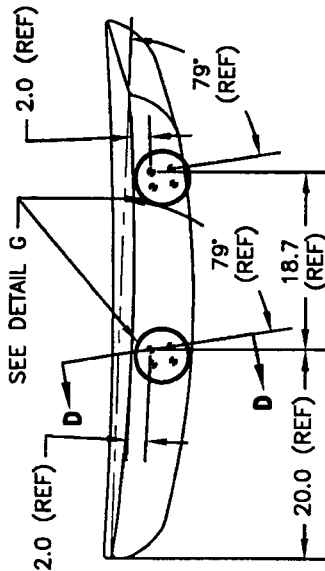
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

**DART**

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 3 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 [Signature]

**DETAIL G**INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)**D3188-2M SPACEPOD BODY**

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WITHOUT NOTICE  
WORK ORDER  
NO. 35070B

D3188-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

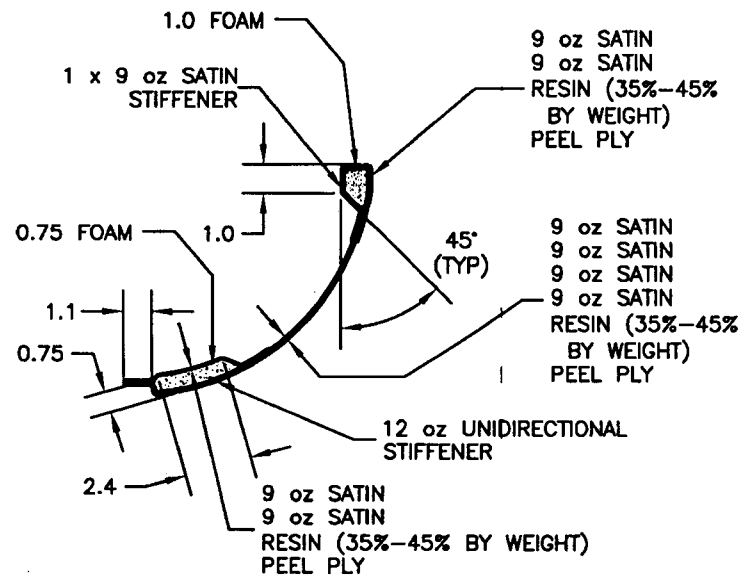
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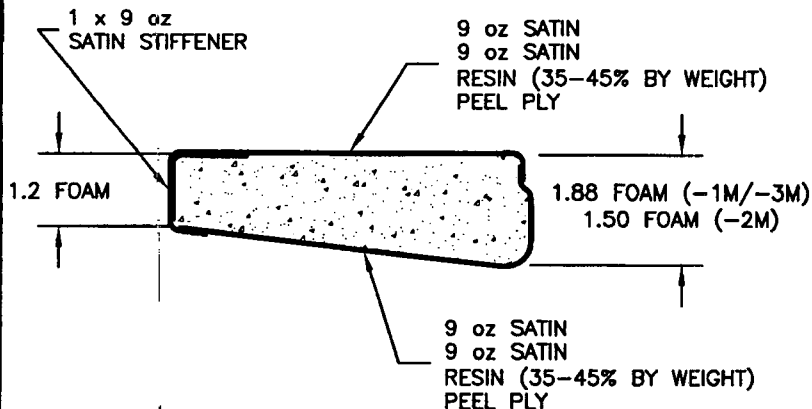
**DART**

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CHECKED	CE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	TITLE	D3188	REV. E
		SPACEPOD BODY		SHEET 4 OF 11
				SCALE
				NTS

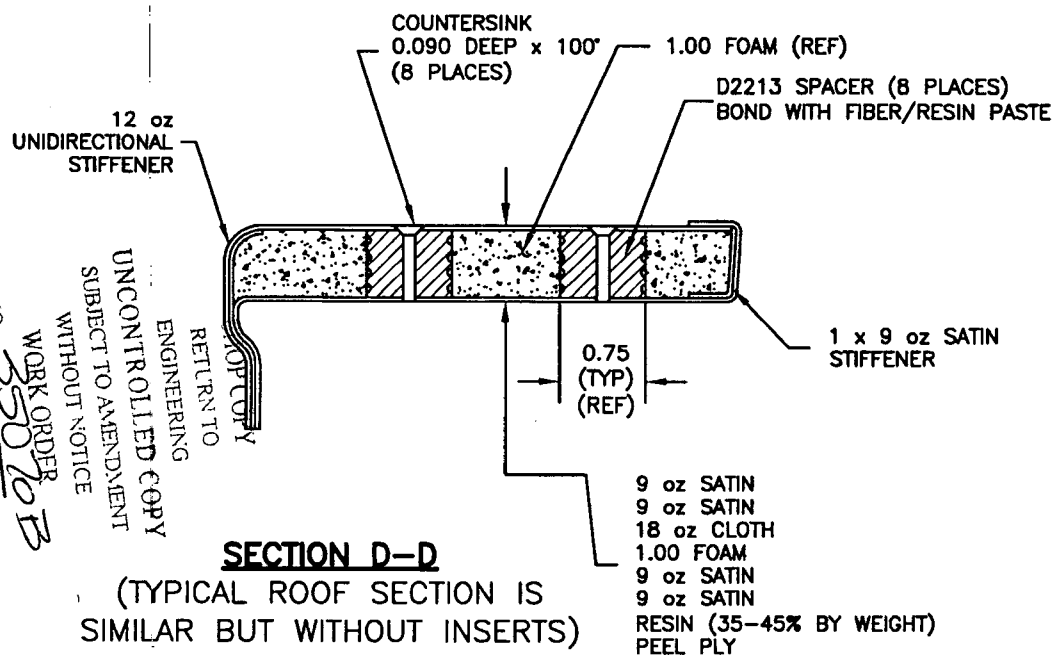
RELEASED  
07.04.01



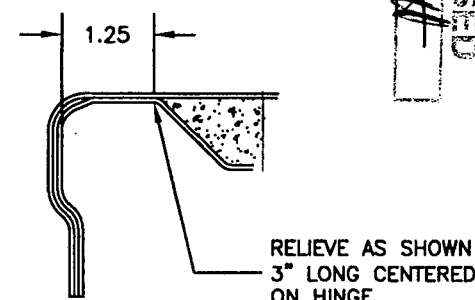
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



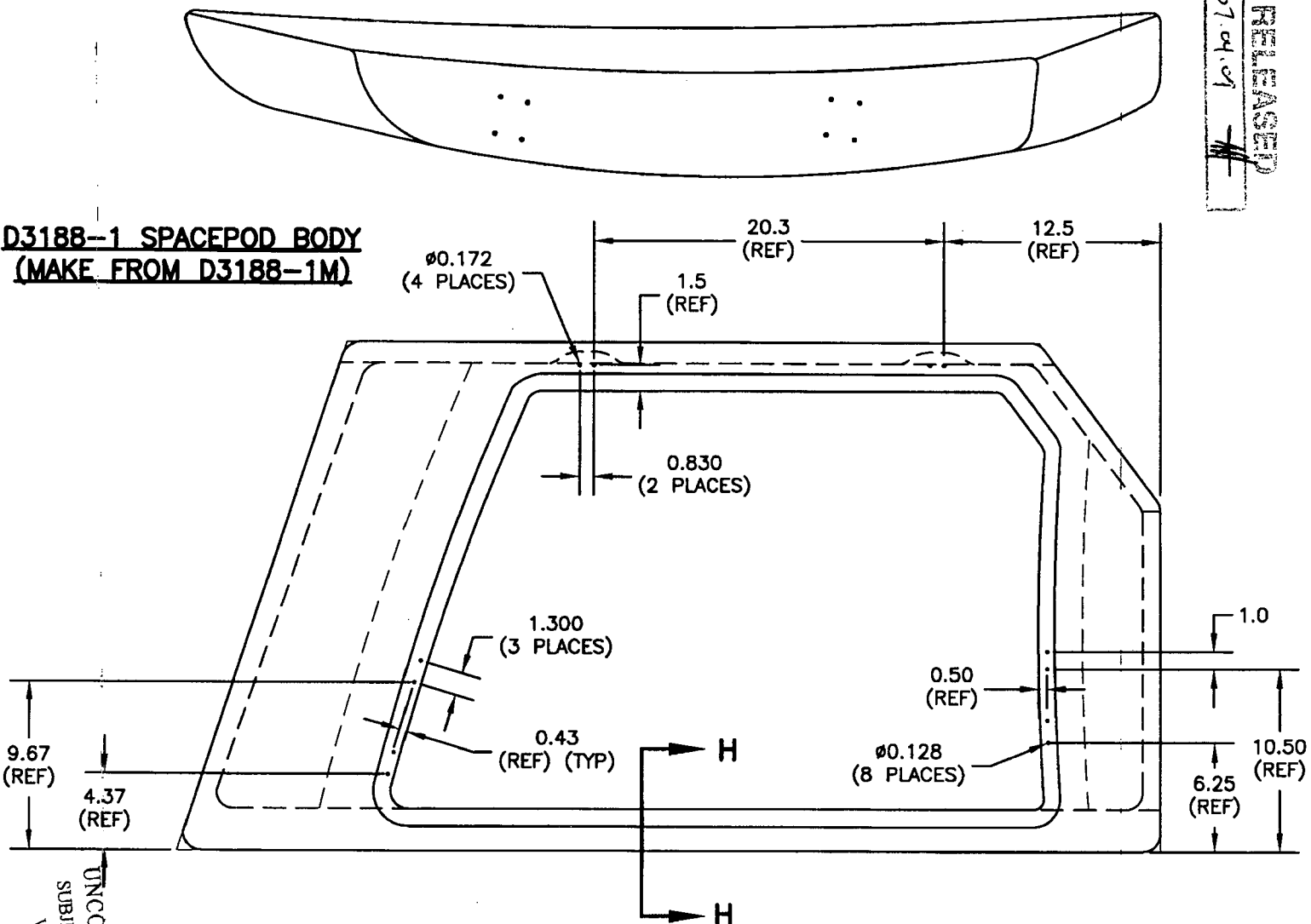
**SECTION E-E**  
(2 PLACES PER POD)

**DART**

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET	5 OF 11	SCALE
				NTS

RELEASED

07.04.02



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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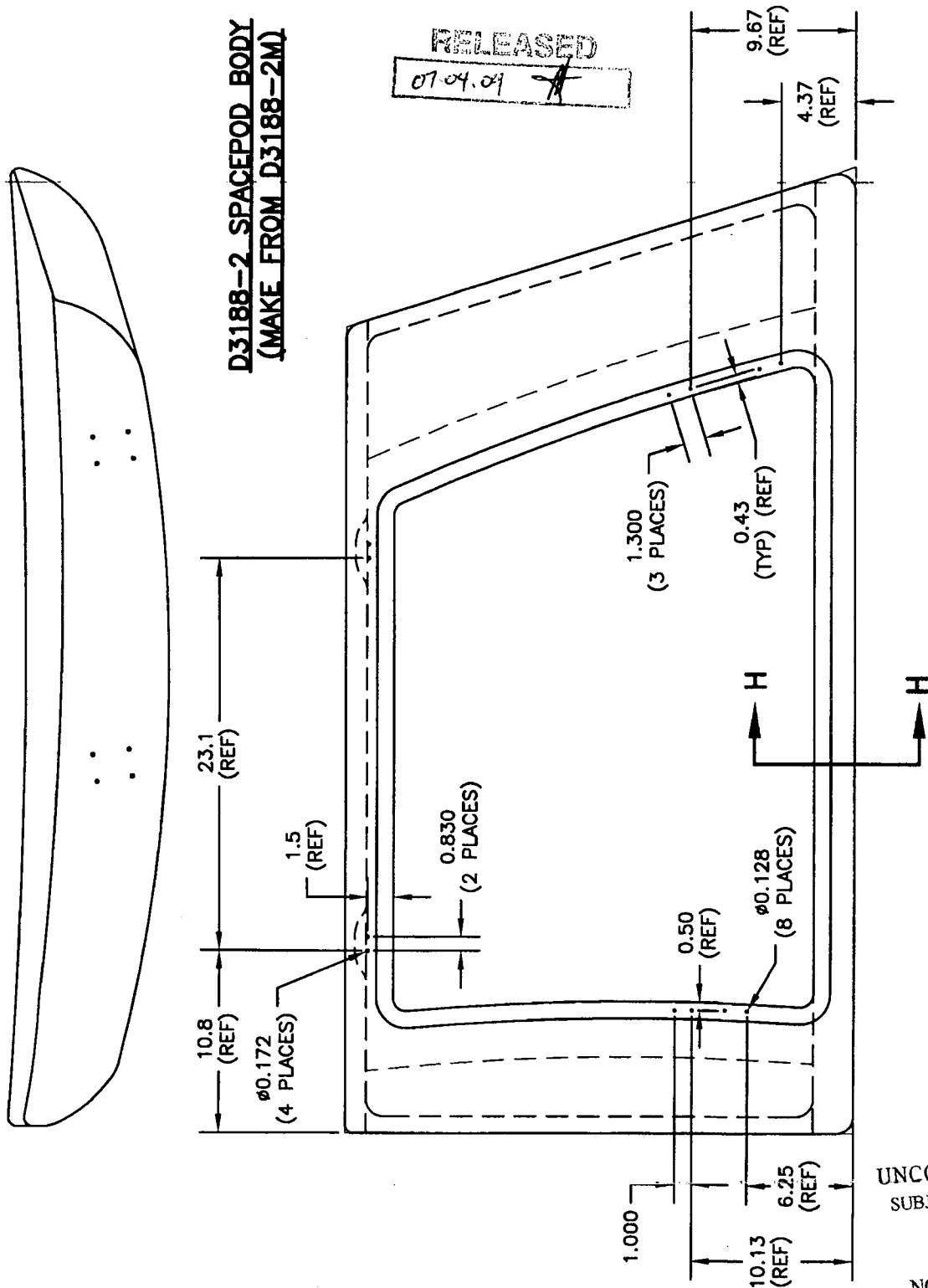
WORK ORDER  
NO. 350703

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**DART**

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 6 OF 11
DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE <b>NTS</b>



**NOTES:**  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY  
2) SEE SHEET #111 FOR SECTION VIEW

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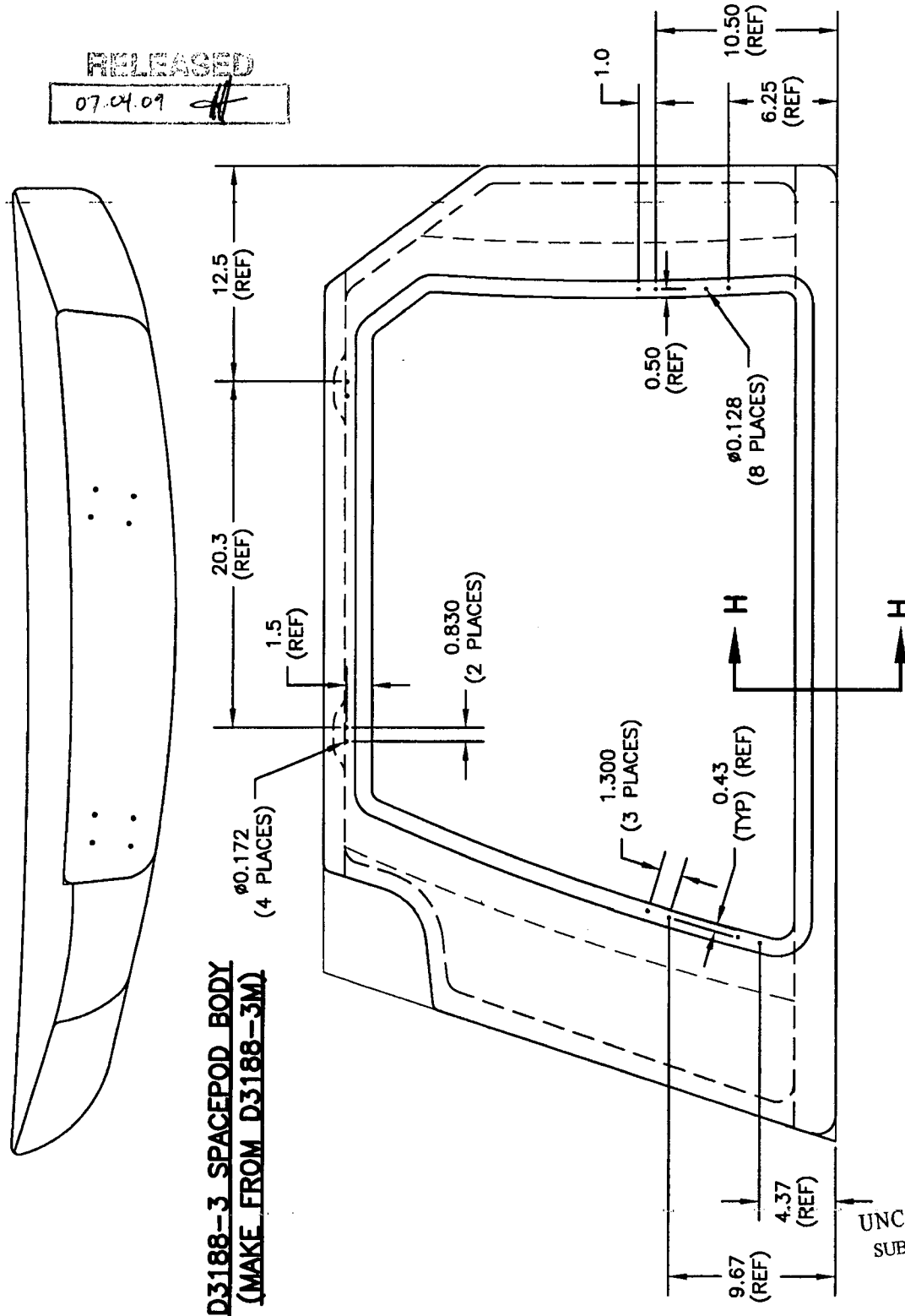
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**DART**

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CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 7 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



- NOTES:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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WORK ORDER  
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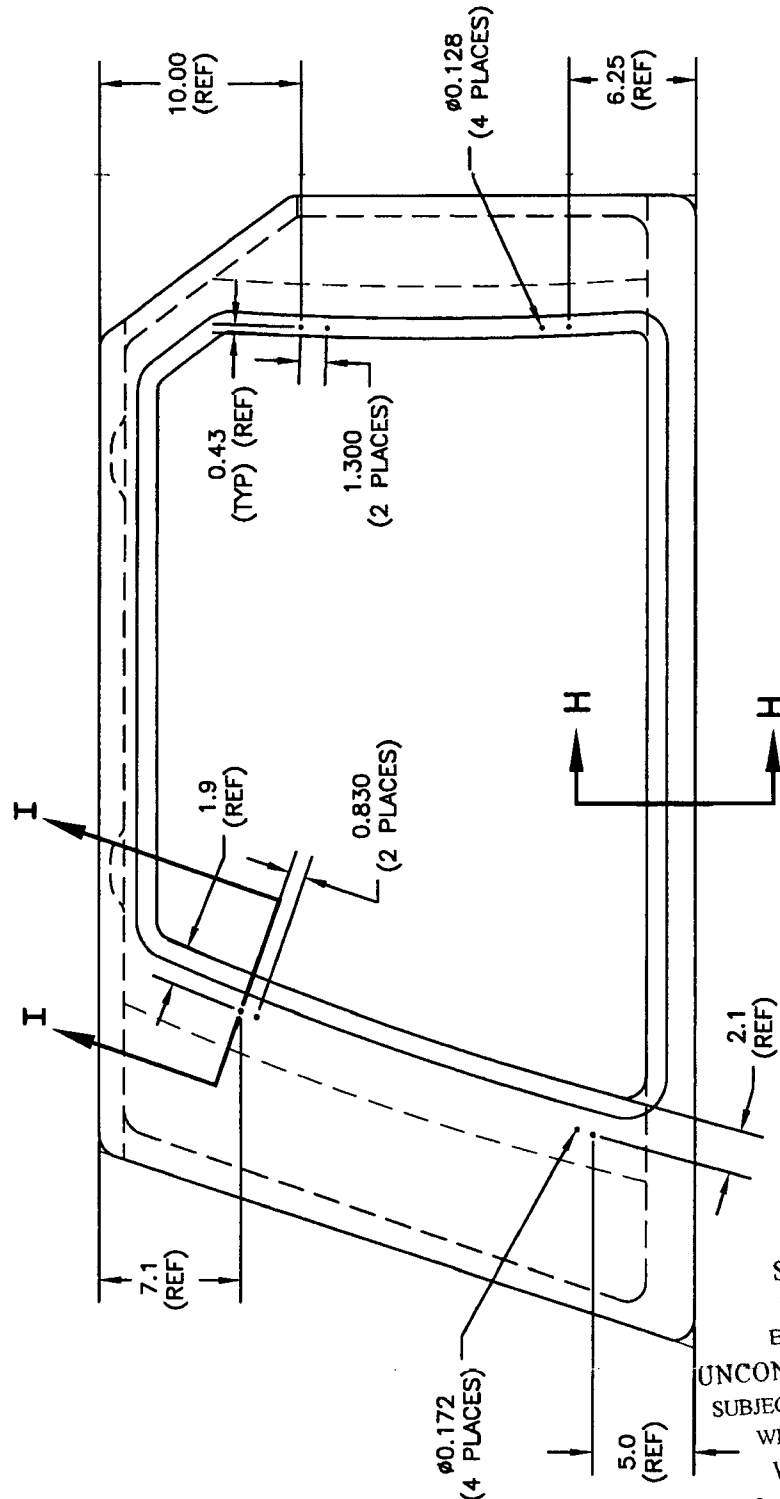
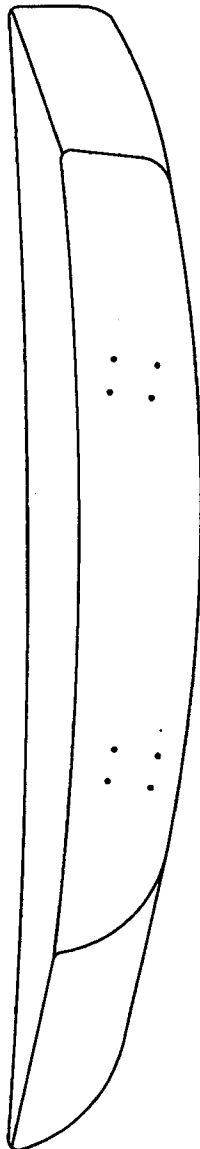
**DART**

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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

RELEASED

07.04.02

**D3188-5 SPACEPOD BODY**  
**(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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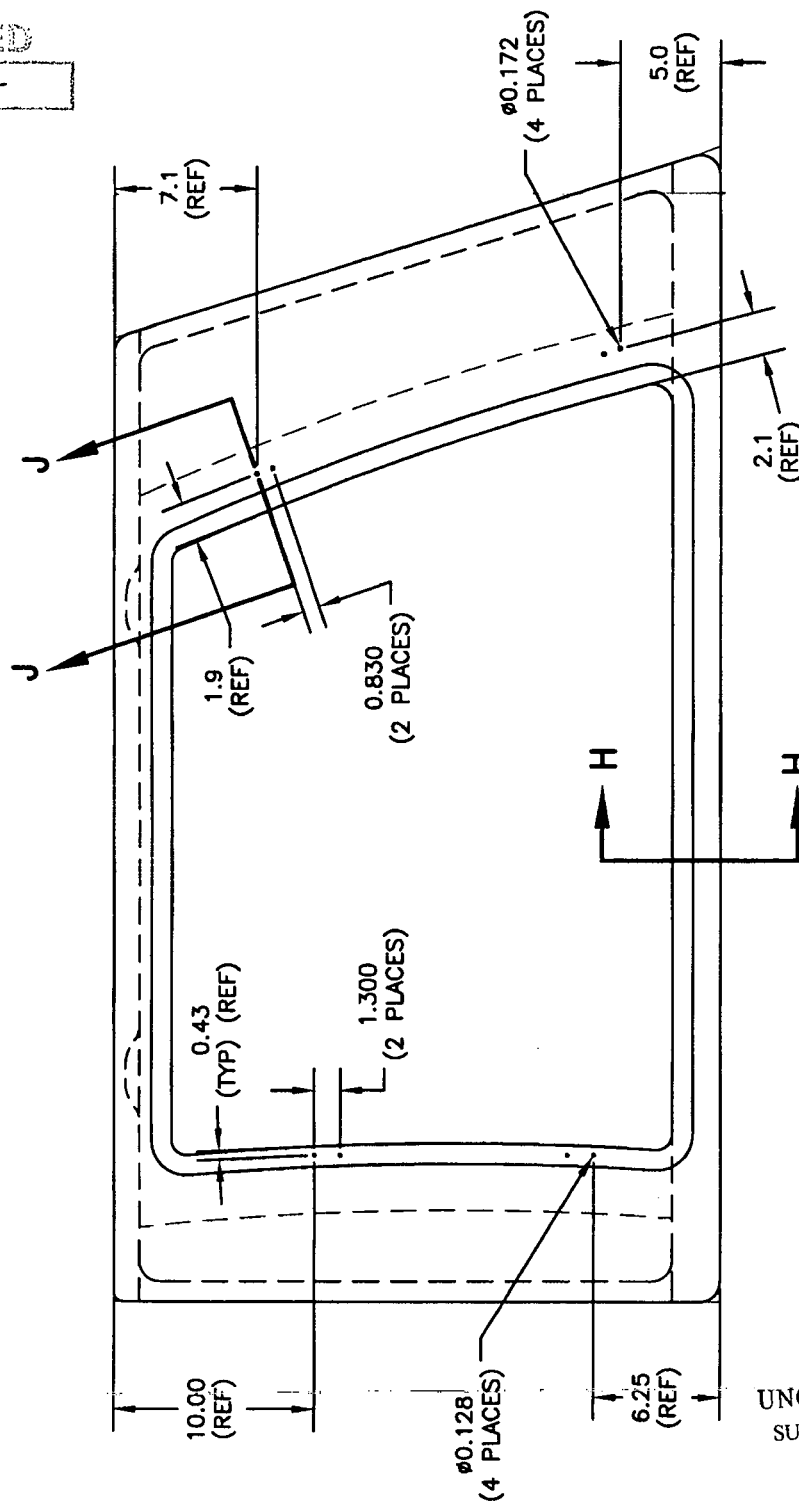
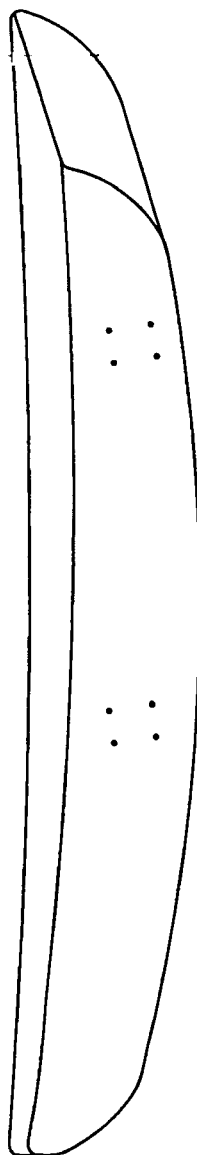
**DART**

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CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 9 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09

**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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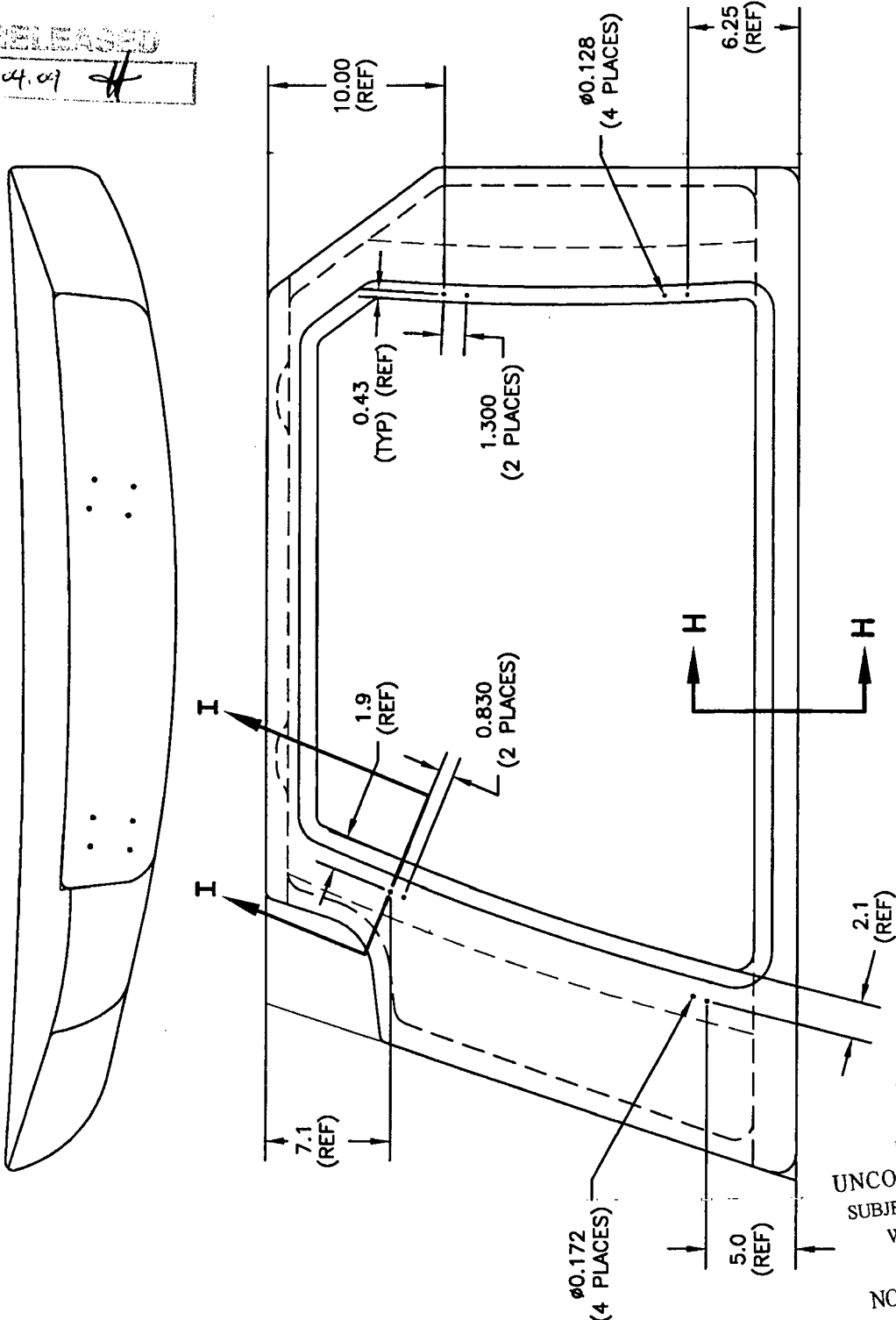
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**

RELEASED  
07.04.02 [Signature]



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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**DART**

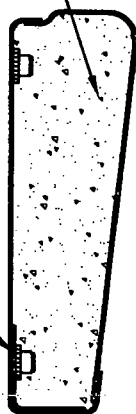
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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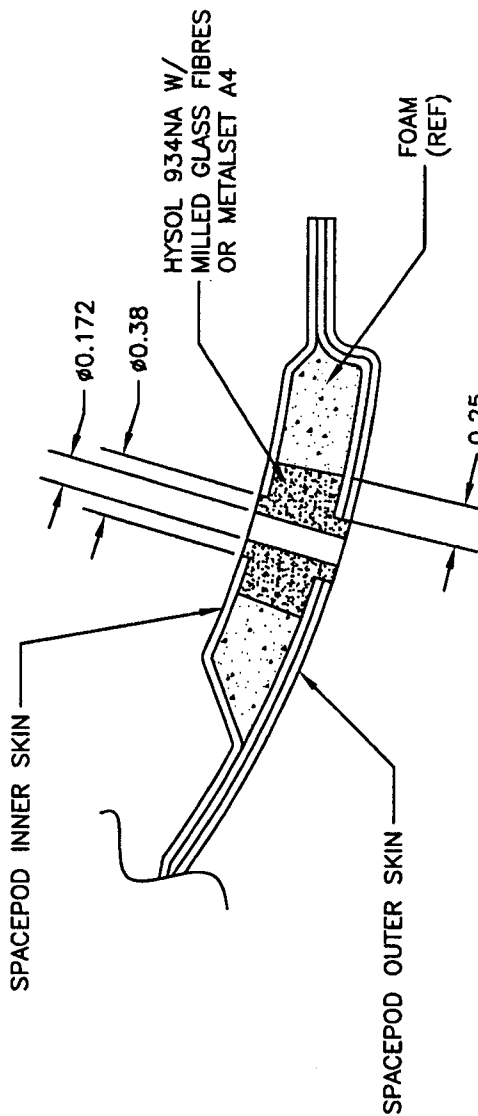
07.04.02 [Signature]

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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DELASTEI COMPOSITES INC.  
2697, Sieme Avenue  
Local 14, PORTE-A-  
Grand-Mere, Quebec G9L 5K7  
Can \*\*Fax (514) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12250-A
Customer #	DART

Telephone: (514) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lucelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
13-11-2007	11-10-2007	5502	Chantal Lavoie		PO000000781		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D31881M Spacepod Body LH B35070B Dwg. Rev. 1 Job: 42140 <i>of 4228</i>			
1	0	1	DKC134-0052	D31861M Spacepod Door LH B35070C01 Dwg. Rev. D Job: 42140			
1	0	1	DKC134-0054	D31862M Spacepod Door RH B35071C01 Dwg. Rev. D Job: 42165			
1	0	1	DKC134-0055	D31882M Spacepod Body RH B35071B Dwg. Rev. 1 Job: 42166  WB #329-003-560-847.854			

It is hereby certified that all materials, process and finished items were  
~~controlled and tested in accordance with the requirements of the purchase~~  
order and applicable specifications. All such records are on file at our plant  
and available for review upon request

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

*Nicolas St. Laurent*  
Quality department

AQ-557

Date: Vendredi, 2007-09-14 14:11:48  
 L1: auteur: Marc Dubé

## Feuille de Procédé

Client :	DART Dart Aerospace Ltd	Nom Dessin :	SPACEPOD BODY
Numéro Job :	42163	Numéro Article :	DKC134-0053
Numéro Soumission :	2585	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numero :	DKC134
Cette fois :	2007-09-14 No. B.V. :	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	Type :	Date Dûe :	2007-09-21 Qté: 1 Udm: UNITE
Job précédente :	42141		

Ecrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31881M

Process Sheet Rev 03 Changer la révision de dessin de C @ E

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Operation: Description:

1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)		
Frekote 44NC		

2.0	PREPARATION 3	PREPARATION DU MATERIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le OSI-006.

Date: SEP 14 2007 Heure Début: 12:30 Heure Fin: 2:00 Scellé: 32

3.0	AC0409	Tissu à delaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total: 9.84 VERGE(s)		
Tissu à delaminer Release ply B		

4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total: 9.27 VERGE(s)		
Wrightlon 5200 Bleu P3		

5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)		
Feutre de drainage N° Airweave N 10		

6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total: 7.00 VERGE(s)		
Stretchlon 200 poche à vide Vert		

Date: Vendredi 2007-09-14 14:11:48

Utilisateur: Marc Dube

## Feuille de Procédé

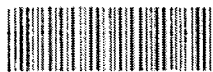
Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 42163

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description:

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#KIT 3-6693-1

8.0 AC0098

Ruban à gommer jaune # T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)

Ruban à gommer jaune # T/AT-200Y

9.0 AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-6176-3

10.0 AAC0633

WR1850 ROVING 18 OZ x 50"

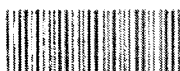
Commentair Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-6211-1

11.0 PREPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 7/10/07 Heure Début: 7:40 Heure Fin: 12:00



12.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6176-3

13.0 AAC0324

Résine (411B7530) 411-350 promo. 75min

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6211-1

14.0 AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0 PREPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.



Date: Vendredi, 2007-09-14 14:11:48  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd  
Numéro Job: 42163

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job



# Séq.: Machine ou Opération: Description :

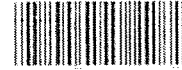
Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxxy 66

Date: SEP 17 2007 Heure Début: 12:30 Heure Fin: 12:40 Sceau:

16.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: SEP 17 2007 Heure Début: 12:40 Heure Fin: 1:20 Sceau:

17.0

POCHE A VIDE 1

FAIRE LA POCHE A VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE A VIDE

Faire la poche a vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac a vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: SEP 17 2007 Heure Début: 1:40 Heure fin: 1:40 Sceau:

Curing Debut: 12:40 Curing Fin: 1:40

18.0

AAC0457

ATC core-cell A500 plain 4 x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3186 de Dart

N° de Lot:

3-5915-2

Date: Vendredi, 2007-09-14 14:11:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 42163

Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs  
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1' selon plan de découpe et gabarits

Date: SEP 18 2007 Heure Début: 12:30 Heure Fin: 2:00 Sceau:

20.0

AAC0324

Résine (411B7530) 411-350 promo 75min

Commentair Qty.: 0 200 KILOGRAMME(s)/Unit Total: 0 200 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6300-1

21.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTÉ(s)/Unit Total: 0.0064 PINTÉ(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

SEP 18 2007



23.0

AAC0452

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)

Polybond B46F

N° de Lot: 1-6253-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées













Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1 Date: SEP 18 2007 Sceau:

Date: Ver. d'ed. 2007-09-14 14:11:48  
Utilisateur: Marc Dube

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 42163		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: _____ Date: _____ Sceau: _____			
25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs TRIMAGE COMPOSITES DART			
Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.			
Quantité: <u>1</u> Date: <u>SEP 20 2007</u> Sceau:  			
Quantité: _____ Date: _____ Sceau: _____			
26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-6300-1</u>			
27.0	AAC0275	Catalyst N° DDM-9	
Commentair Qty: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>1-6118-3</u>			
28.0	PREPARATION 3	PREPARATION DU MATERIEL DART	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs PRÉPARATION DU MATÉRIEL DART			
SEP 20 2007 			
Faire la préparation de la résine selon les quantité requises. mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes.			
29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs FABRICATION GÉNÉRALE DART			
Retirer les pièces de foam core du moule			
Sceller les foam core à l'aide de la résine promu 75 minutes. Selon T.G. # Sceller le Foam Core			
Laisser sécher pendant 2 heures minimum.			
Date: <u>SEP 20 2007</u> Sceau:   initiales: <u>C.G. M.G</u>			

Date: Vendredi, 2007-09-14 14:11:48  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42163

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job



# Séq.: Machine ou Opération: Description:

30.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)  
Polybond B46F N° de Lot: 1-6283-1

31.0 PREPARATION 3 PREPARATION DU MATERIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond

Date: SEP 21 2007 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: SEP 21 2007 Heure Début: 12:35 Heure Fin: 1:10 Sceau:



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé

Date: SEP 21 2007 Heure Début: 1:10 Heure Fin: 1:30 Sceau:



Curing Début: 12:35 Curing Fin: 1:50



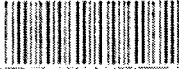








34.0 ACC058 Polysoft 1.3 kg #003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6284-1

Date: vendredi, 2007-09-14 14:11:48  
Utilisateur: Marc Dubé












## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 42163		Numéro Article: DKC134-0053	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
35.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
36.0	FINITION 3	FINITION PIÉCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs FINITION GÉNÉRALE  Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts, utiliser du polybond.  Date: <u>SEP 24 2007</u> Heure Début: <u>8:00</u> Heure Fin: <u>9:00</u> Sceau:  			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs TRIMAGE COMPOSITES DART  Tailler la foam core afin d'ajuster le contour de la pièce à celui du moule. <u>SEP 24 2007</u> 			
38.0	AAC0374	Résine (411B7530) 411-350 promo 75min	
Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s) Résine (411B7530) 411-350 promo 75min  N° de Lot: <u>1-6330-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s) Catalyst N° DDM-9  N° de Lot: <u>1-6118-3</u>			
40.0	FINITION 3	FINITION PIÉCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs FINITION PIÉCE DART  Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core  Laisser sécher pendant 2 heures minimum.  Quantité: <u>1</u> Date: <u>SEP 24 2007</u> Sceau:   Quantité: _____ Date: _____ Sceau: _____			

Date: Vendred., 2007-09-14 14:11:48





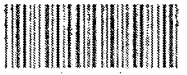




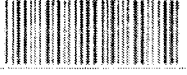
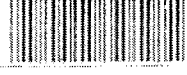

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 42163		Numéro Article: DKC134-0053	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0504 PINTE(s)/Unit Total: 0.0504 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>1-618-3</u>			
42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-6330 1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			
SEP 25 2007 8:00 8:15			
Heure Début: 8:00 Heure Fin: 8:15 Sceau: 			
44.0	LAMINAGE	LAMINAGE PIECE DART	
			
Commentaire Setup: 0.03Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS			
Laminer deux pli de 9.7 oz 7781 partout dans le moule			
Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.			
SEP 25 2007 8:15 9:15			
Heure Début: 8:15 Heure Fin: 9:15 Sceau:   			
45.0	POCHE A VIDE 1	FAIRE LA POCHE A VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs EFFECTUER LA POCHE A VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à délaminer.			
2- Film perforé P-3.			
3- Feutre de drainage			
4- Sac à vide Stretchlon 200			
Laisser sécher pendant 4 heures minimum.			

Date: Vendredi 2007 09 14 14:11:48  
Utilisateur: Marc Dube








## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 42163		Numéro Article: DKC134-0053	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>SEP 25 2007</u> Heure Début: <u>8:15</u> Heure Fin: <u>9:15</u> Sceau:   		
	Curing Début: <u>8:15</u> Curing Fin: <u>2:45</u>		
46 0	DÉMOULAGE 1	DÉMOULAGE PIECE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs DÉMOULAGE DES PIECES			
Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.			
	Date: <u>SEP 26 2007</u> Heure Début: <u>9:30</u> Heure Fin: <u>9:40</u> Sceau:   		
47 0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs TRIMAGE DE FINITION			
Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.			
Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. ( Ne pas percer la peau extérieur de la pièce )			
	Date: <u>SEP 26 2007</u> Heure Début: <u>10:20</u> Heure Fin: <u>11:05</u> Sceau: 		
48 0	AAC0275	Catalyst N° DDM 9	
Commentaire Qty: 0.0048 PINTÉ(s)/Unit Total: 0.0048 PINTÉ(s) Catalyst N° DDM-9			
N° de Lot: <u>1-6118-3</u>			
49 0	AAC0324	Resine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total: 0.150 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-6330-1</u>			
50 0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s) Fibre de verre Miapoxy 66			
N° de Lot: <u>1-59-51-1</u>			

Date: Vendredi, 2007-09-14 14:11:48

Utilisateur: Marc Dubé


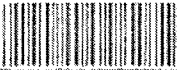
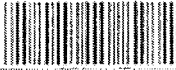






## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY
Numéro Job: 42163		Numéro Article: DKC134-0053
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
51.0	PREPARATION 3	PREPARATION DU MATÉRIEL DART
 		
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL		
Faire la préparation de la résine selon les quantité requises, mix ration 1 5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.		
SEP 2 8 2007 Date: _____ Heure Début: 8:50 Heure Fin: 9:00 Sceau: 		
52.0	AAC0448	Spacer N° D2213
Commentaire Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s) Spacer N° D2213 N° de Lot: 1-6250-2		
53.0	ASSEMBLAGE 3	ASSEMBLAGE GENERALE DART
 		
Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs ASSEMBLAGE GÉNÉRALE DES PIÉCES		
Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargée à l'aide de Fibre de verre Miapoxy 66		
Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous.		
Appliquer une pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes		
Laisser sécher pendant 4 heures minimum		
SEP 2 8 2007 Date: _____ Heure Début: 9:00 Heure Fin: 9:10 Sceau: 		
Curing Début: 9:00 Curing Fin: 1:10		
54.0	AAC0275	Catalyst N° DDM-9
Commentaire Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s) Catalyst N° DDM-9		
N° de Lot: 1-6118-3		
55.0	AAC0324	Résine (411B7530) 411-350 promo 75min
Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.		
N° de Lot: 1-6330-1		










Date: Vendredi, 2007-09-14 14:11:48  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 42163		Numéro Article: DKC134-0053	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1 5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>SEP 28 2007</u> Heure Début: <u>1:25</u> Heure Fin: <u>1:25</u> Sceau: </p>			
57.0	LAMINAGE	LAMINAGE PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS</p> <p>Retirer les pinces et les blocs de bois</p> <p>Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce selon le dessin.</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>SEP 28 2007</u> Heure Début: <u>1:25</u> Heure Fin: <u>1:35</u> Sceau: </p> <p>Curing Début: <u>1:25</u> Curing Fin: <u>8:00</u></p>			
58.0	FINITION 3	FINITION PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART</p> <p>Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.</p> <p>Percer les 8 trous des spacers afin de les déboucher.</p> <p>Quantité: <u>1</u> Date: <u>19/10/07</u> Sceau: _____</p> <p>Quantité: _____ Date: _____ Sceau: _____</p>			
59.0	AAC0671	Dupont Primer N° 1104S	
<p>Commentaire Qty: <u>0.5000 GALLON(s)/Unit</u> Total: <u>0.5000 GALLON(s)</u> Dupont Primer N° 1104S <u>16282-1</u></p>			

Date: Vendredi 2002-09-14 14:11:48  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd	Nom Dessin: SPACEPOD BODY
Numéro Job: 42163	Numéro Article: DKC134-0053
Numéro Job 	
# Séq.:	Machine ou Opération: Description :
53.0 AAC0670	Dupont Activator N° 7975S
Commentaire Qty.: 1.0000 PINTE(s)/Unit Total: 1.0000 PINTE(s) Dupont Activator N° 7975S 1-6149-3	
54.0 AAC0672	Dupont Reducer N° 12375S
Commentaire Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s) Dupont Reducer N° 12375S 1-6065-3	
62.0 PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
  Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs PRÉPARATION DU MATÉRIEL DART  Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant	
63.0 PEINT/PRIMER2	PEINTURE / PRIMER DART
  Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs PEINTURE / PRIMER DART  Appliquer le primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. Application de primer.  Laisser sécher 3 heures minimum  Date: 17/09/02 Heure Début: 11:30 Heure Fin: 12:30 Sceau:	
64.0 AC0058	Polysoft 1.3 kg # 003012 Sikkens
Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens  N° de Lot: 6284-1	
65.0 AC0059	Durcisseur Polysoft #004009 Sikkens
Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens	
66.0 FINITION 3	FINITION PIÈCE DART
  Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs FINITION GÉNÉRALE  Faire les réparations de finition s'il y a lieu à l'aide de Sikkens  Faire un léger sablage ( grit 220 ) de toutes les surfaces.  Date: 22/09/02 Heure Début: 9:00 Heure Fin: 1:00 Sceau:	

Date: Vendredi, 2007-09-14 14:11:43

Utilisateur: Marc D. Be

## Feuille de Procédé

Client: DAR\* Dart Aerospace Ltd

Nom Dessin: SPACEPOD BODY

Numéro Job: 42163

Numéro Article: DKC134-0053

Numéro Job



# Séq.: Machine ou Opération: Description:

570 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6222-1

680 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTÉ(s)/Unit Total: 0.5000 PINTÉ(s)  
Dupont Activator N° 7975S N° de Lot: 1-6199-3

690 AAC0672 Dupont Reducer N° 12375S

Commentair Qty: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-6065-3

700 PREPARATION 3 PREPARATION DU MATERIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

PREPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

Date: 22/10/07 Sceau:

Date: Sceau:

710 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

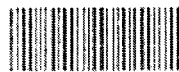
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

Date: 22/10/07 Heure Début: 2:00 Heure Fin: 2:30 Sceau:

720 INSPECTION 3 INSPECTION PIECE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 23/10/07 Sceau: Initiales: H.S.

Date: Vendredi, 2007-09-14 14:11:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42163

Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job



# Séq.:

Machine ou Opération:

Description :

73.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 23-10-07 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

Date: Wednesday, 10/10/2007 11:02:11 AM  
 User: Kim Johnston

## Process Sheet

46

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 35070C01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 10/10/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33901C01	Material	:
Written By	:	Due Date	: 11/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>071010</u>		
Comment	: Est Rev: A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 4784C 20711011

Description: D3186-1M Door

Supplier: Delastek

0

Conformity Certificate and Process sheet required

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

7-11-14 SQ 1x

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins. Ensure surface of  
 doo is smooth, no dimples for drilling.

07-12-06

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GAm 07/12/06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/10/2007 11:02:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 35070C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

① 07/12/13

Job Completion



mi 2007/12/12

07.12.13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

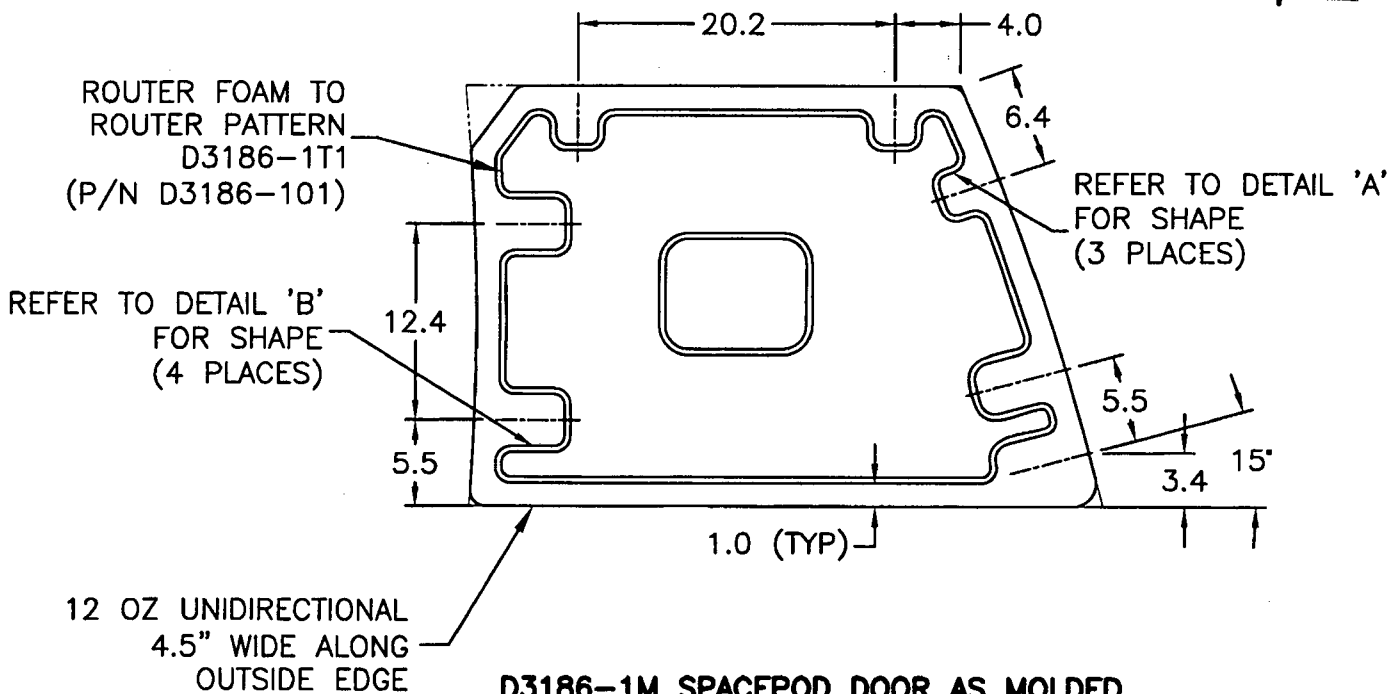
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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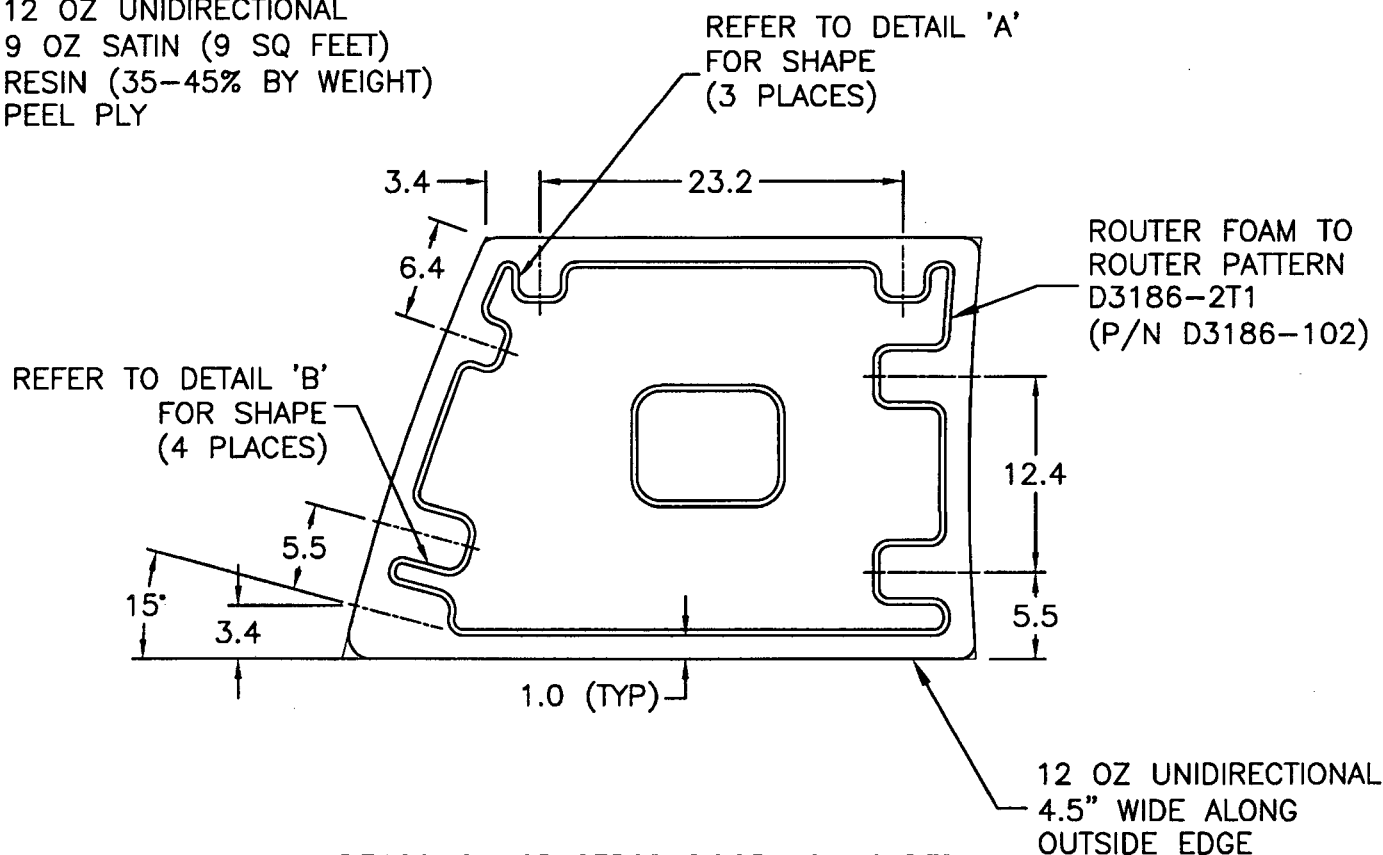
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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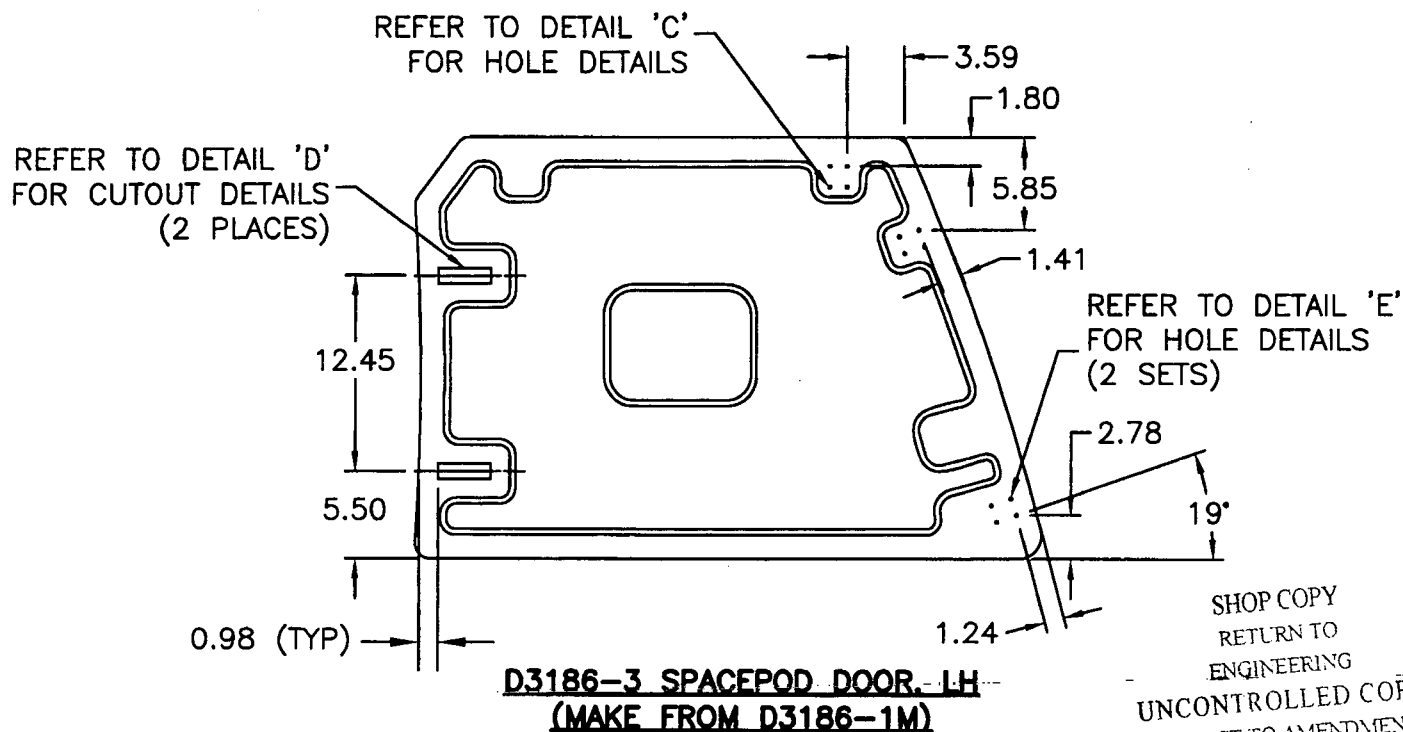
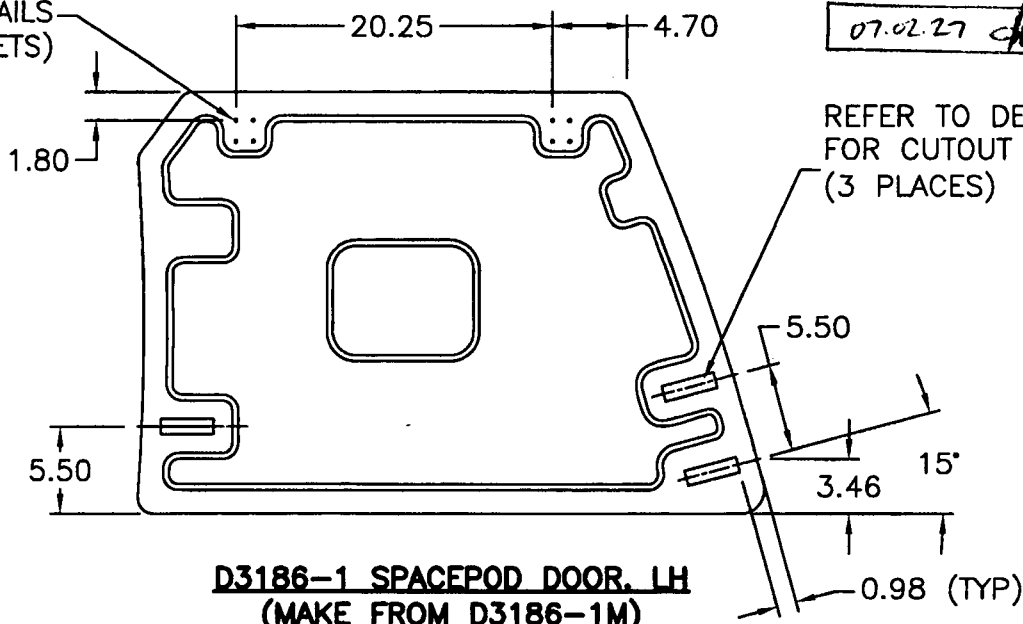
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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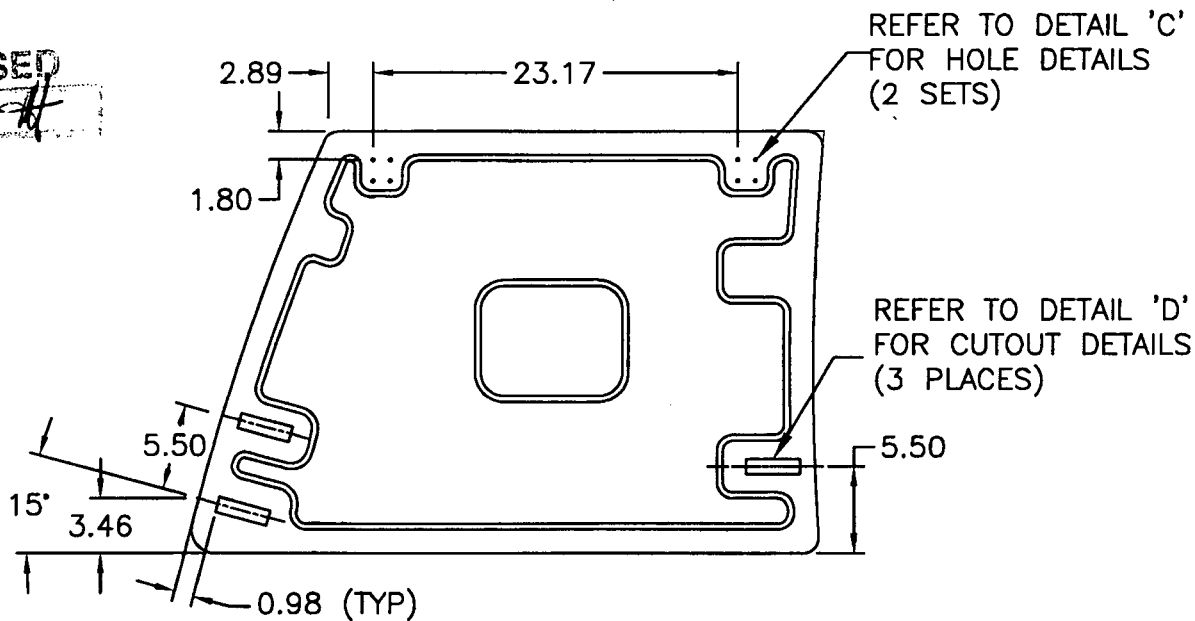
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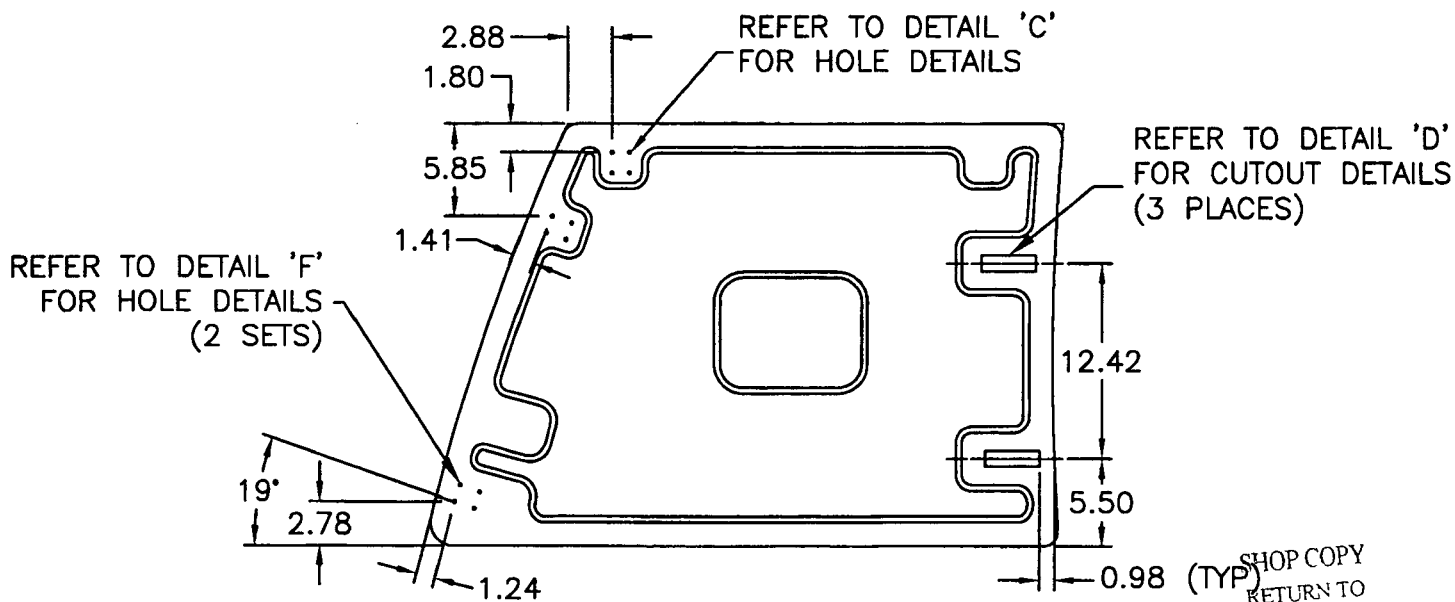


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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED  
07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

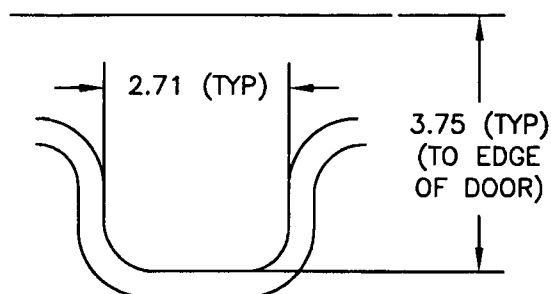
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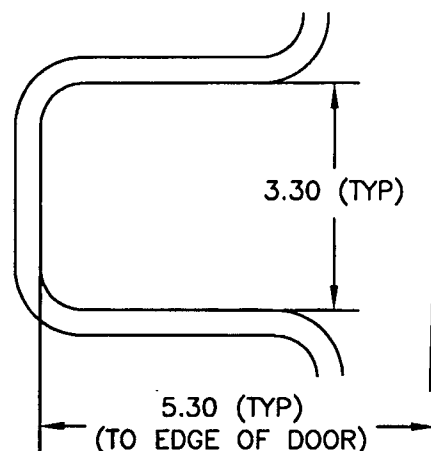
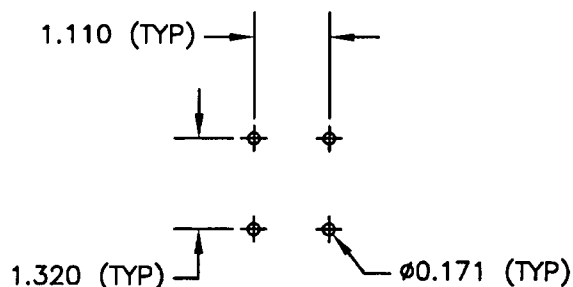
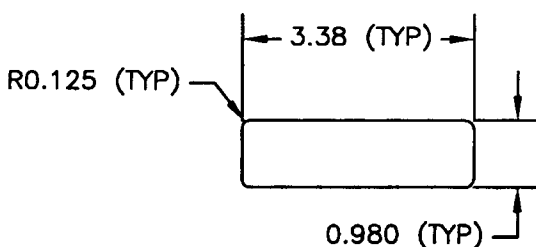
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**DART**

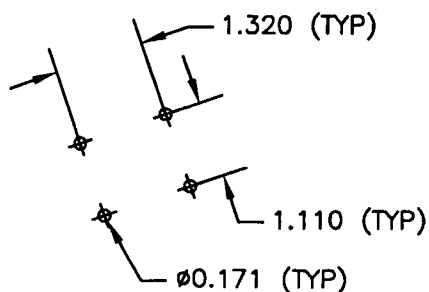
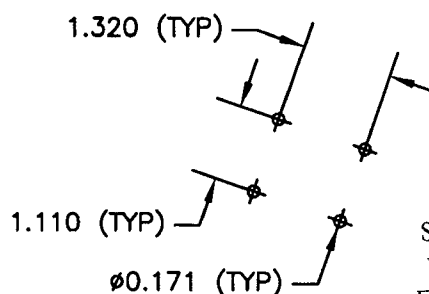
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DELASTEI COMPOSITES INC.  
2695, Steeple Avenue  
Local 13, PORTER, N.S.  
Grand-Mère, Québec G9P 1K7  
Can. (514) 533-4444

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12250-A
Customer #	DART

Telephone: (514) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-622-5200  
Contact: Linda Lucelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net 30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
13-11-2007	11-10-2007	5502	Chantal Lavoye	PO-000000081			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D31881M Spacepod Body LH B35070B Dwg Rev. 1 Job: 42163			
1	0	1	DKC134-0052	D31861M Spacepod Body LH B35070B Dwg Rev. 1 Job: 42163			
1	0	1	DKC134-0054	D31862M Spacepod Door RH B35071C01 Dwg Rev. 1 Job: 42163			
1	0	1	DKC134-0055	D31882M Spacepod Body RH B35071B Dwg Rev. 1 Job: 42166			
				WB #129-002-860847854			
						U de M : Each	
						U de M : Each	
						U de M : Each	
						U de M : Each	

It is hereby certified that all materials, process and finished items were controlled and issued in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



Quality department

AQ-557



DELASTEK COMPOSITES INC.  
2699, Steeple Avenue  
Local 14, PORTE-SA  
Grand-Mere, Quebec J6T 5K7  
Can. \*\*Fax (519) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12250-A
Customer #	DART

Telephone: (519) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-622-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
13.11.2007	11.10.2007	5502	Chantal Layotte		PO00004784		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D31881M Spacepod Body LH B35070B U de M : Each Dwg. Rev. F Job: 42163			
1	0	1	DKC134-0052	D31861M Spacepod Door LH B35070C01 U de M : Each Dwg. Rev. D Job: 42140			
1	0	1	DKC134-0054	D31862M Spacepod Door RH B35071C01 U de M : Each Dwg. Rev. D Job: 42165			
1	0	1	DKC134-0055	D31882M Spacepod Body RH B35071B U de M : Each Dwg. Rev. F Job: 42166			
				WB #329-003-560-847-554			

It is hereby certified that all materials, process and finished items were examined and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: Nick St. Louis  
Quality department AQ-557




Date: Mercredi, 2007-09-05 10:50:29  
 Utilisateur: Marc Dubé

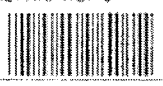


## Feuille de Procédé

Client : DART Dart Aerospace Ltd	Nom Dessin : SPACEPOD DOOR
Numéro Job : 42140	Numéro Article : DKC134-0052
Numéro Soumission : 2584	Numéro Dessin : D3186
Numéro B.A. :	Projet Numéro : DKC134
Cette fois : 2007-09-05 No. B.V. :	Révision dessin : 2
Prsht Rev. : NC	Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - - Type :	Date Dûe : 2007-09-06 Qté: 1 UoM: UNITE
Job précédente : 42035	
Écrit par : _____	
Vérifié & Approuvé par : _____	
Commentaires : N° de pièce Dart Aerospace : D31861M	

Process Sheet Rev. 02 Ajoute une séquence d'emballage et une séquence d'inspection du positionnement du foam core

Produit additionnel

Numéro Job 

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty: 0.020 GALLON(s)/Unit Total: 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATERIEL DART
 		
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le OSI-006 SEP 17 2007 Date: _____ Heure Début: 8:00 Heure Fin: 10:00 Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty: 3.28 VERGE(s)/Unit Total: 3.28 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty: 3.59 VERGE(s)/Unit Total: 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s) Stretchlon 200 poche à vide Vert		



Date: ~~Version~~ 2002-09-25 10:50:29

Utilisateur: Marc Dube

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42140

Numéro Article: DKC134-0052

Numéro Job



# Séq.: Machine ou Opération: Description :

7.0 AAC0581 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish #LOT 1-6219-1

8.0 AAC0098

Ruban à gommer jaune # T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-6170-3

10.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide

À fin d'accélérer le processus de tailage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 7/06/01 Heure Début: 10:15 Heure Fin: 12:00 Sceau: 32

11.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0080 PINTÉ(s)/Unit Total: 0.0080 PINTÉ(s)

Catalyst N° DDM-9 N° de Lot: 1-6118-3

12.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6300-1

13.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs










PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: SEP 18 2002 Heure Début: 2:00 Heure Fin: 2:05 Sceau: 32


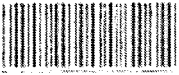
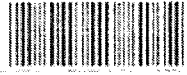






Date: Mercredi 2007-09-05 10:50:29  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42140		Numéro Article: DKC134-0052	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
14.0	LAMINAGE	LAMINAGE PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs FAIRE LE LAMINAGE DES TISSUS</p> <p>À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz</p> <p>Recommencer l'opération pour le deuxième pli.</p> <p>Date: <u>SEP 18 2007</u> Heure Début: <u>2:05</u> Heure Fin: <u>2:20</u> Sceau:  </p>			
15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs EFFECTUER LA POCHE A VIDE</p> <p>Faire la poche à vide en appliquant les composantes dans l'ordre suivant:</p> <ul style="list-style-type: none"><li>1- Tissu à délaminer.</li><li>2- Film perforé P-3,</li><li>3- Feutre de drainage</li><li>4- Sac à vide Stretchlon 200</li></ul> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>SEP 18 2007</u> Heure Début: <u>2:20</u> Heure Fin: <u>2:30</u> Sceau:  </p> <p>Curing Début: <u>2:05</u> Curing Fin: <u>7:00</u></p>			
16.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty: 0.0120 PINTÉ(s)/Unit Total: 0.0120 PINTÉ(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>1-6178-3</u></p>			
17.0	AAC0324	Resine (411B7530) 411-350 promo 75min.	
<p>Commentaire Qty: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6300-1</u></p>			

Date: Mercredi 2007-09-05 10:50:29  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numero Job: 42140		Numero Article: DKC134-0052	
Numero Job			
# Séq.:	Machine ou Opération:	Description :	
18.0	PREPARATION 3	PREPARATION DU MATERIEL DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.			
Laisse sécher pendant 2 heures.			
Date: <u>SEP 18 2007</u> Heure Début: <u>2:30</u> Heure Fin: <u>2:45</u> Sceau: 			
19.0	DKC134-0056	Foam Core N° D3186-101 ( Porte D3186-1 )	
<b>Commentaire</b> Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D3186-101 ( Porte D3186-1 )			
N° de Job: <u>42016</u>			
20.0	AAC0452	Polybond B46F	
<b>Commentaire</b> Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s) Polybond B46F N° de Lot: <u>1-6253-1</u>			
21.0	ASSEMBLAGE 3	ASSEMBLAGE GENERALE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES			
Retirez le bagging.			
Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.			
Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )			
L'inspection du positionnement doit être fait par le département de la qualité.			
Date: _____ Sceau: _____ Initiales: <u>N/A</u> 			
Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.			
Date: <u>SEP 24 2007</u> Heure Début: <u>9:30</u> Heure Fin: <u>10:00</u> Sceau:  			

Date: Mercredi, 2007-09-05 13:50:29  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42140

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

22 0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond.

SEP 7 4 2007

Date:

Heure Début:

10:15

Heure Fin:

10:25

Sceau:



Curing Début:

9:30

Curing Fin:

10:45

23 0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

24 0

AAC0324

Resine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1 000 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6330-1

25 0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

SEP 7 5 2007

Date:

Heure Début:

2:45

Heure Fin:

3:00

Sceau:

SEP 7



Date: Mercredi, 2007-09-05 10:50:29

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42140

Numéro Article: DKC134-0052

Numéro Job



# Séq.:

Machine ou Opération:

Description:

26.0

LAMINAGE

LAMINAGE PIECE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte

Faire le laminage du dernier pli de 9.7 oz.

Date: SEP 2 5 2007 Heure Début: 3:15 Heure Fin: 4:15 Sceau:  

27.0

POCHE A VIDE 1

FAIRE LA POCHE A VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: SEP 2 5 2007 Heure Début: 4:15 Heure Fin: 4:25 Sceau:  

Curing Debut: 3:15 Curing Fin: 8:00

28.0

DEMOULAGE 1

DEMOULAGE PIECE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".








Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date: SEP 2 7 2007 Heure Début: 11:30 Heure Fin: 11:40 Sceau: \_\_\_\_\_

Date: Mercredi 2007-09-05 10:50:29

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42140		Numéro Article: DKC134-0052	
Numéro Job			
# Séq.:	Machine ou Opération:	Description :	
29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs TRIMAGE DE FINITION  Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.  Date: <u>09/07/2007</u> Heure Début: <u>2:40</u> Heure Fin: <u>3:55</u> Sceau: _____			
30.0	AAC0671	Dupont Primer N° 1104S	
<b>Commentaire</b> Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s) Dupont Primer N° 1104S <u>1.6149-1</u>			
31.0	AAC0670	Dupont Activator N° 7975S	
<b>Commentaire</b> Qty.: 0.2800 PINTÉ(s)/Unit Total: 0.2800 PINTÉ(s) Dupont Activator N° 7975S <u>1.6254-1</u>			
32.0	AAC0672	Dupont Reducer N° 12375S	
<b>Commentaire</b> Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s) Dupont Reducer N° 12375S <u>1.6065-3</u>			
33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs PRÉPARATION DU MATÉRIEL DART  Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.  Date: <u>09/07/2007</u> Sceau: _____  Date: _____ Sceau: _____			
34.0	PEINT: PRIMER2	PEINTURE / PRIMER DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs PEINTURE / PRIMER DART  Appliquer la première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. # Application du primer.  Laisser sécher pendant 3 heures.  Date: <u>09/07/2007</u> Heure Début: <u>1:40</u> Heure Fin: <u>2:40</u> Sceau: _____			

Date: Mercredi, 2007-09-05 10:50:30  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42140

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job



# Séq.: Machine ou Opération: Description :

35.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0 AAC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

37.0 AAC0046 MASTIC POLYSTOP SIKKENS 3AR591

Commentaire Qty.: 0.050 KIT(s)/Unit Total: 0.050 KIT(s)  
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AAC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6284-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 18/09/07 Heure Début: 11:00 Heure Fin: 12:50 Sceau:

40.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6282-1

41.0 AAC0670 Dupont Activation N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activation N° 7975S N° de Lot: 1-6282-3

42.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-6065-3

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instructions du fabricant.

Date: Mercredi, 2007-09-05 10:50:30  
Utilisateur: Marc Dube

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42140

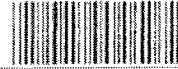
Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job



# Séq.: Machine ou Opération: Description:

44.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. #

Application du primer

22/07/07 200 250  
Date: 22/07/07 Heure Début: 1:35 Heure Fin: 2:00 Sceau:

45.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
INSPECTION PIÈCE DART

Quantité: 1 Date: 23/007 Sceau:  95.

Quantité: Date: Sceau:

46.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 23-10-07 Sceau: 

Quantité: Date: Sceau:



## Chantal Lavoie

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**From:** Simon Hébert [shebert@delastek.com]  
**Sent:** Tuesday, November 20, 2007 9:37 AM  
**To:** clavoie@dartaero.com  
**Subject:** NRC 251

Hello Chantal,

Concernant le NRC 251

Les révisions sont :

D3186-2 la rev. est C  
D3188-1 la rev. est C  
D3186-1 la rev. est C  
D3188-2 la rev. est B

Si vous avez des questions laissez-moi le savoir

Merci,

Simon Hébert

Tél: (819) 533-5788 Ext 235  
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[shebert@delastek.com](mailto:shebert@delastek.com)

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